ORDNANCE FIELD SERVICE

BASE SHOP DATA

Rifle, Auto., Cal. .30, Browning M1918A2

PREPARED UNDER THE DIRECTION OF THE
CHIEF OF ORDNANCE

ROCK ISLAND ARSENAL.- FEB.. 1943

16 October 1943*

Ordnance Field Service Base Shop Data

Rifle, Auto., Cal. .30, Browning M1918A2

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* Replaces List of Contents, Issue of February 1943

Ordnance Field Service Base Shop Data

Rifle, Auto., Cal. .30, Browning

M1918A2

LIST OF REFERENCES

STANDARD NOMENCLATURE LISTS	
List of Drawings	51-90
Major Items of Group A	SNL A-1
Rifle, Automatic, Cal..30, Browning, M1918, M1918A1, and M1918A2.	SNL A-4
Tools, Maintenance, for repair of Automatic guns, automatic gun Antiaircraft materiel, Automatic and Semiautomatic cannon, and Mortars - individual items and parts	SNL A-35
Small arms, automatic gun, trench Mortar and field artillery sighting equipment and fire control instruments, Major Items	SNL F-1
Sights, Bore (Small Arms & Field Artillery-Parts)	SNL F-10
Targets, testing (Small Arms & Field Artillery)	SNL F-12
Glass, Field, Type EE, 6 power parts & equip.	SNL F-34
Firing tables and trajectory charts	SNL F-69
Trucks, Small Arms, repair, M1.	SNL G-72
Cleaning, preserving and lubricating Materials, special oils, and similar items of issue	SNL K-1
Soldering, brazing and welding material, gases and related items	SNL K-2
Targets and target equipment, small arms	SNL L-1
Measuring, impression, testing and reconditioning outfits	SNL N-9
Ammunition, rifle and automatic gun	SNL T-1
Miscellaneous service components of Small Arms ammunition and instruction material for Field Service Account	SNL T-4
Index to Current SNL	OPSI
FIELD MANUALS	
Ordnance Field Manual	FM 9-5
Ordnance Field Maintenance	FM 9-10
List of Publications for Training	FM 21-6
Defense Against Chemical Attack	FM 21-40
Browning Automatic Rifle, Cal..30, M1918A2 with Bipod	FM 23-15
Browning Automatic Rifle, Cal..30, M1918A2 without Bipod	FM 23-20
TECHNICAL MANUALS	
Cleaning, Preserving, Lubricating & Welding Materials and Similar Items (Now published as TR1395-A)	TM 9-850
Browning Automatic Rifle, Cal..30, All types	TM 9-1211
Field Glass, Type EE	TM 9-1611
ORDNANCE FIELD SERVICE BULLETINS	
Maintenance of materiel in hands of troops	OFSB 4-1
Electric & Oxyacetylene Welding	OFSB 5-2

28 October 1943

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CONVERSION LIST OF TOOL DRAWINGS

B.S.D. NO.	O.O. NO.	NOMENCLATURE
908977	B316001	Alignment Tool, Buffer Tube B147493
908979	B316002	Fixture, Rear Sight Base
908981	B316003	Fixture, Holding, Leaf, Rear Sight
909006	B316004	Test Tool, Length of Bolt Assem. B19695
909179	B316005	Wrench - To Remove & Replace Barrel
909180	B316006	Block, Vise, Barrel Holding
	A77201	Gage, Ring
	A77204	Gage, Plug
	B147001	Reflector, Barrel
	C7719	Gage, Headspace, Cal.30
	C64145	Tool, Combination
A2401	D7106205	Fixture, Grinding, Bolt Block Assem.

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ROCK ISLAND ARSENAL,- FEB.. 1943

B.S.D. No.

Dismantling 1

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 1 OF 13

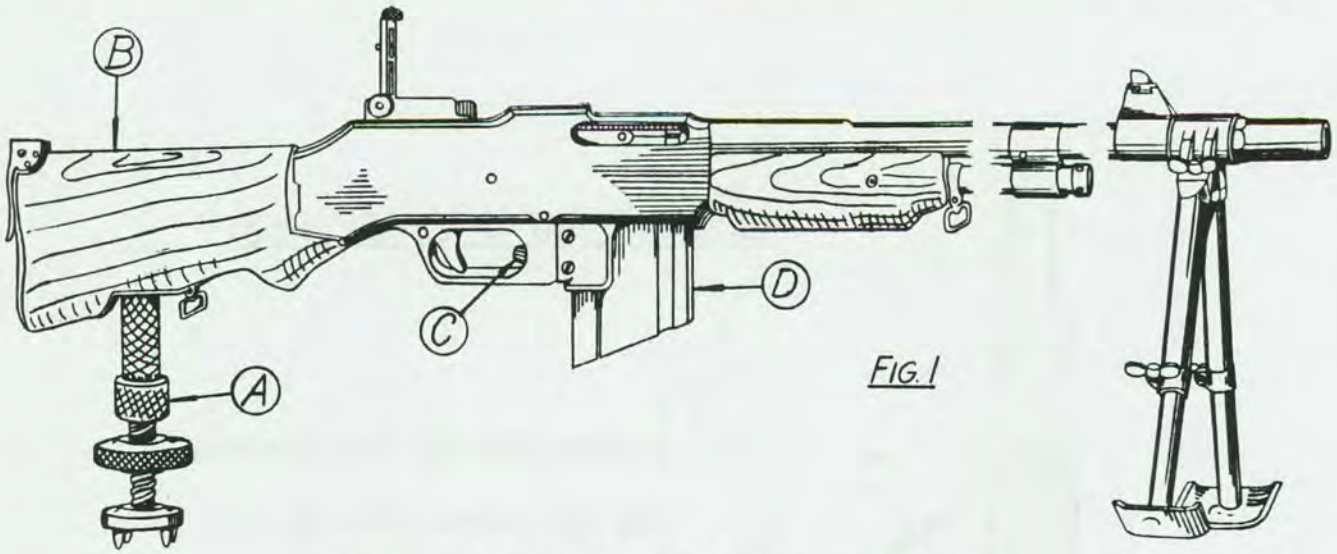


FIG. 1

REMOVAL OF STOCK REST AND MAGAZINE

1. PULL THE STOCK REST (A) FROM THE BUSHING IN STOCK (B), FIG. 1. PRESS MAGAZINE RELEASE (C) AND REMOVE MAGAZINE (D)

2. SLIDE OUT BASE (E), KEEPING THUMB OVER BOTTOM OF MAGAZINE (D) TO PREVENT SPRING (F) FROM FLYING OUT, FIG. 2. REMOVE SPRING (F) AND FOLLOWER (H).

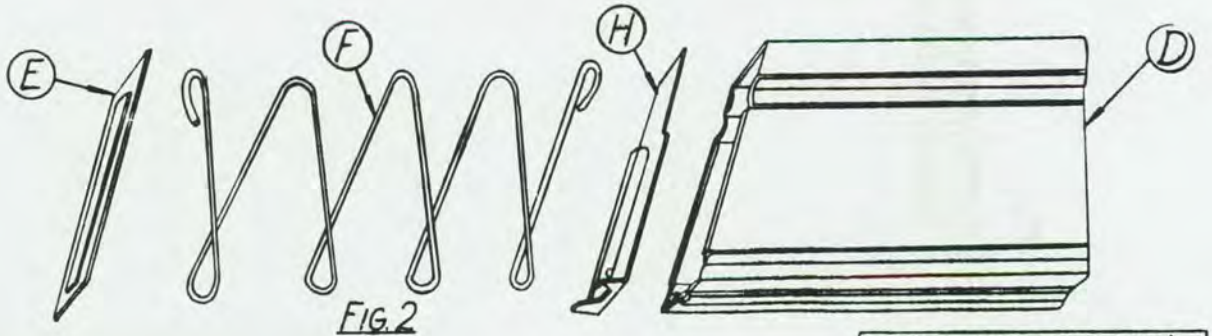
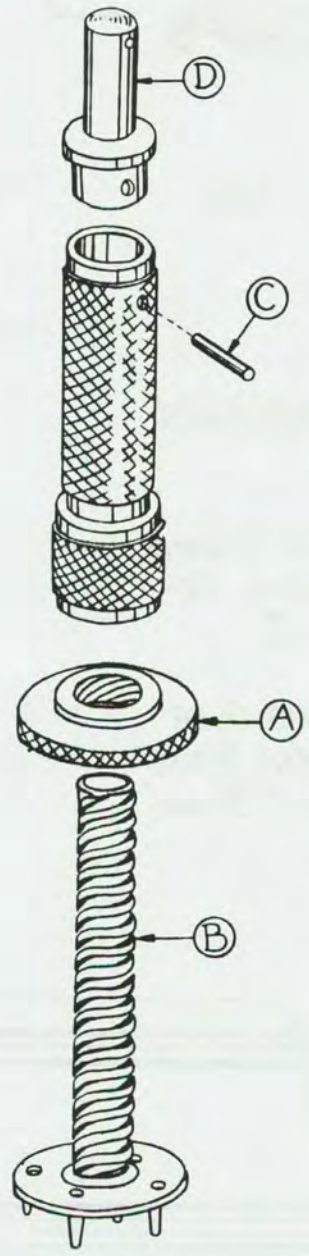


FIG. 2

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 2 OF 13



DISMANTLING OF STOCK REST

(3) LOOSEN LOCK (A) AND UNSCREW LEG (B). SCREW LOCK (A) OFF LEG (B). DRIVE OUT PIN (C) AND REMOVE STEM (D).

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 3 OF 13

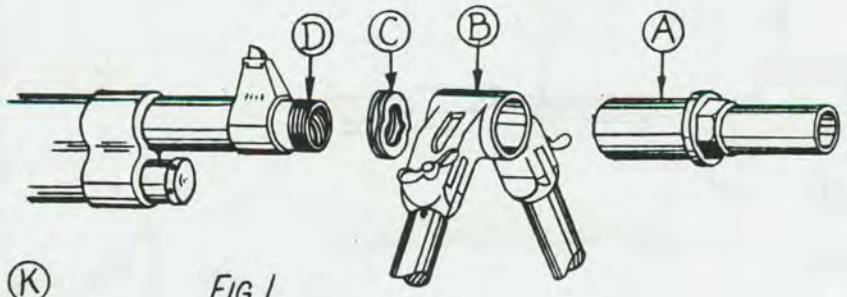


FIG. 1

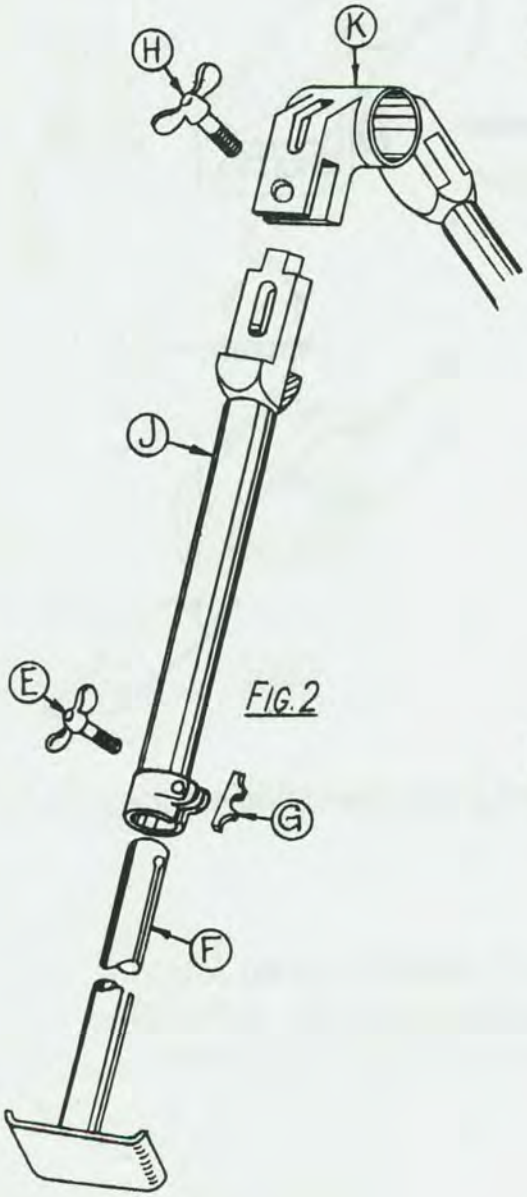


FIG. 2

REMOVAL OF BIPOD

4 UNSCREW FLASH HIDER (A), FIG. 1. REMOVE THE BIPOD (B) FROM THE FLASH HIDER (A) AND THE FRICTION WASHER (C) FROM BARREL (D).

DISMANTLING OF BIPOD

5 REMOVE SCREW (E). SLIDE OUT LEG (F) AND REMOVE KEY (G). FIG. 2. REMOVE SCREW (H) AND PULL TUBE (J) FROM BODY (K).

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 4 OF 13

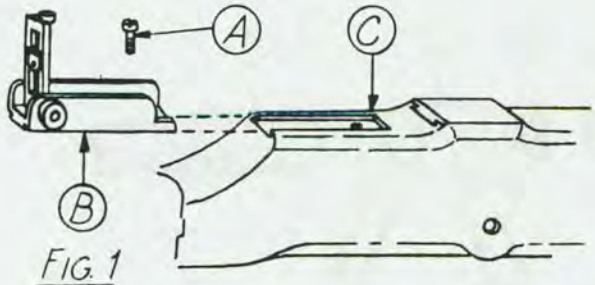
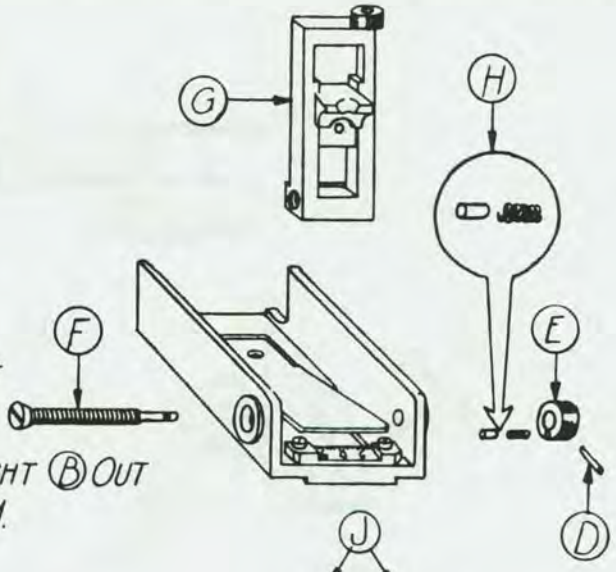


FIG. 1



REMOVAL AND DISMANTLING OF REAR SIGHT

6 EXTRACT SCREW (A) AND DRIVE REAR SIGHT (B) OUT OF RECEIVER (C) WITH A BRASS BAR, FIG. 1.

7 DRIVE OUT PIN (D), FIG. 2. REMOVE KNOB (E). UNSCREW WINDAGE SCREW (F). REMOVE SIGHT LEAF (G). PULL SPRING AND PLUNGER (H) FROM KNOB (E).

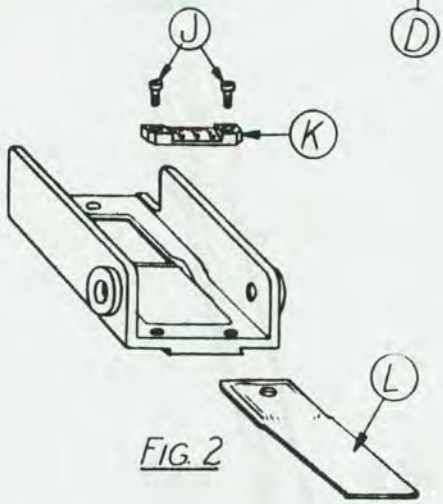


FIG. 2

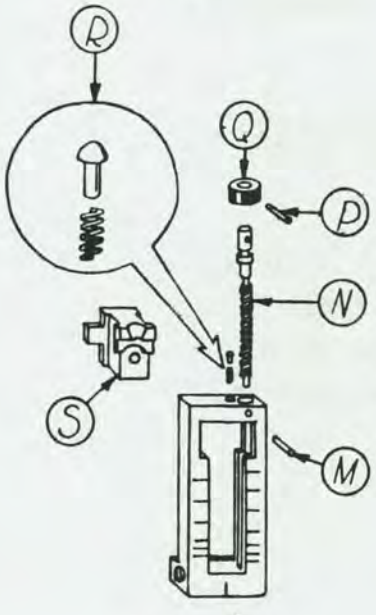


FIG. 3

8 EXTRACT TWO SCREWS (J) AND REMOVE WINDAGE SCALE (K). PULL OUT SPRING (L).

9 TAP OUT PIN (M), FIG. 3. REMOVE ELEVATING SCREW (N). DRIVE OUT PIN (P) AND REMOVE KNOB (Q). REMOVE SPRING AND PLUNGER (R). LIFT SLIDE (S) TO TOP OF SIGHT LEAF AND REMOVE.

SMALL ARMS RIFLE, AUTO CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 5 OF 13

REMOVAL OF CYLINDER TUBE AND FOREARM

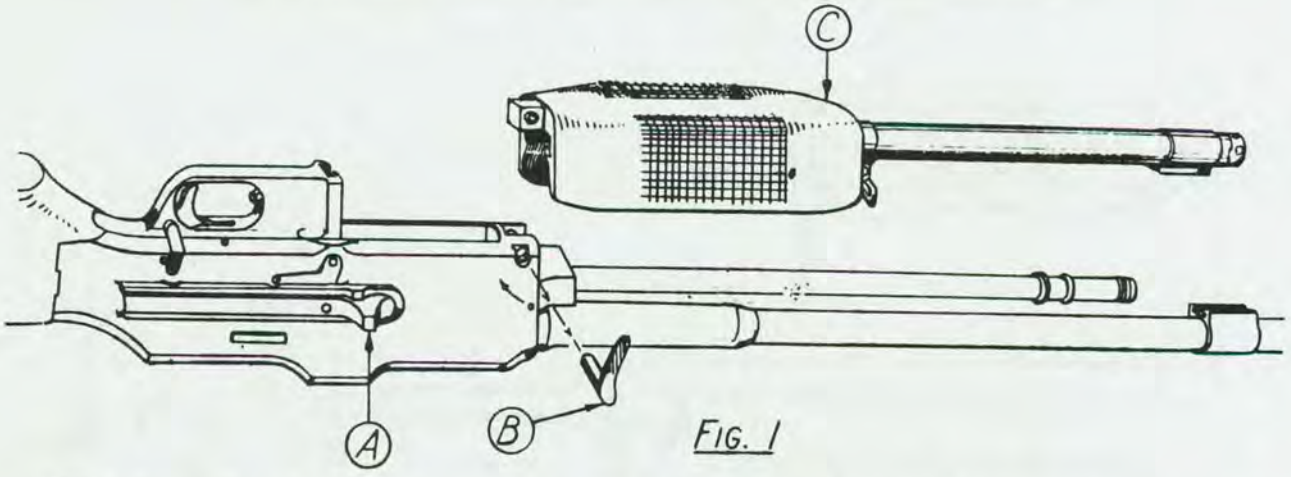
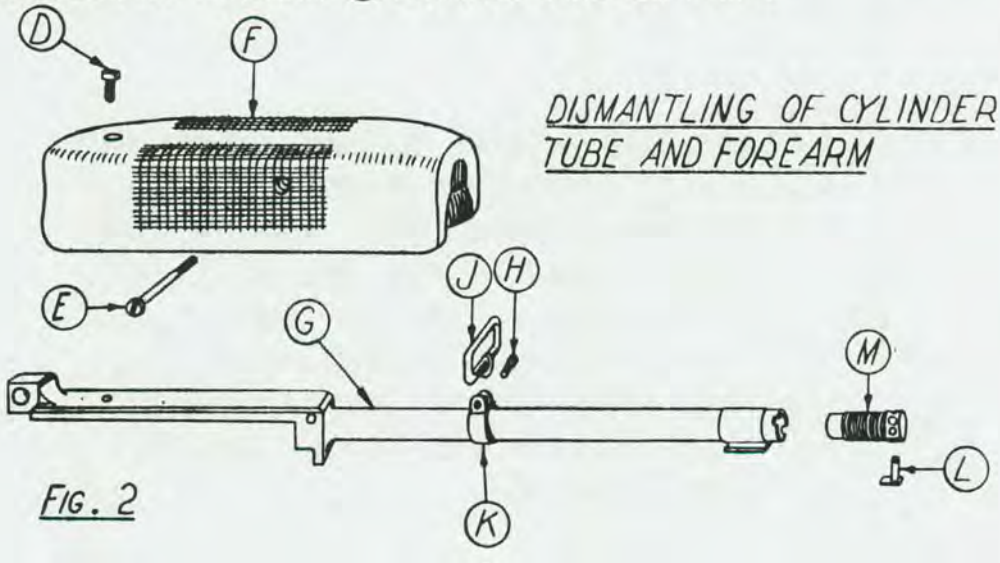


FIG. 1

(10) COCK THE GUN BY RETRACTING OPERATING HANDLE (A) AND RETURNING TO FORWARD POSITION. TURN GAS CYLINDER TUBE RETAINING PIN SPRING (B) 180° IN CLOCKWISE DIRECTION. PULL OUT RETAINING PIN SPRING (B) SLIDE CYLINDER TUBE AND FOREARM (C) FORWARD AND LIFT UP.



DISMANTLING OF CYLINDER TUBE AND FOREARM

FIG. 2

(11) REMOVE SCREW (D) AND SCREW (E). LIFT FOREARM (F) FROM GAS CYLINDER TUBE (G). REMOVE SCREW (H) AND SLING SWIVEL (J). PRY OPEN BRACKET (K) AND REMOVE FROM TUBE. DRIVE OUT GAS CYLINDER LOCK (L). UNSCREW GAS CYLINDER (M).

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 6 OF 13

REMOVAL OF TRIGGER GUARD GROUP, RECOIL GUIDE AND SPRING

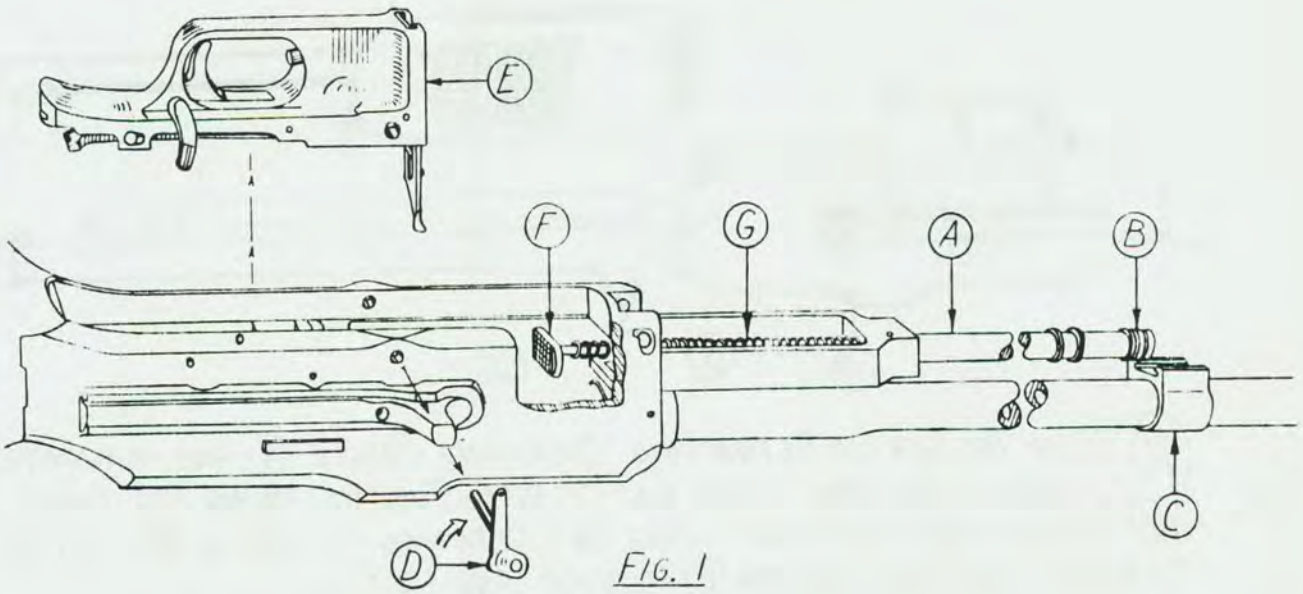
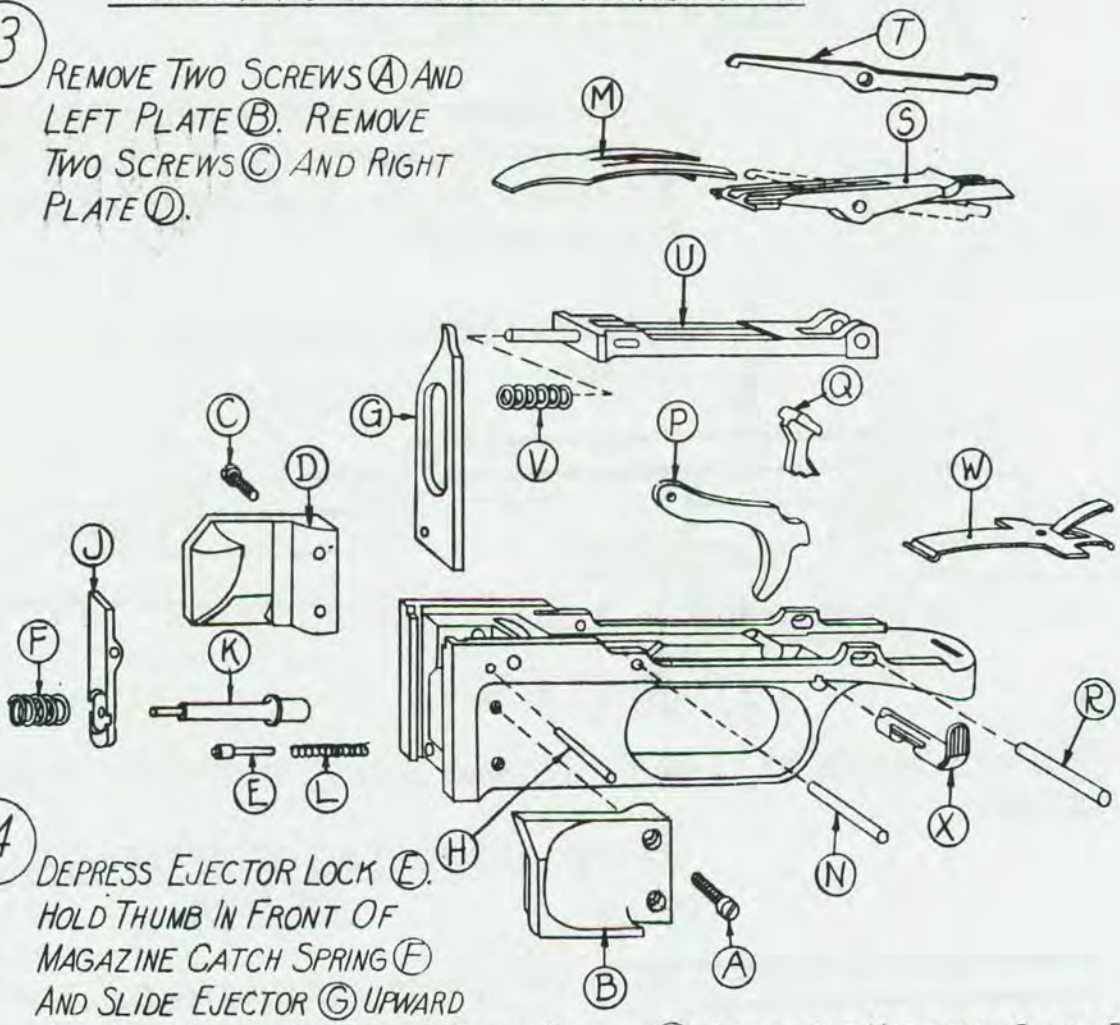


FIG. 1

(12) PULL THE TRIGGER, HOLDING THE PISTON ROD (A) TO PREVENT PISTON (B) FROM STRIKING BRACKET (C). TURN TRIGGER GUARD RETAINING PIN SPRING (D) 90° IN A CLOCKWISE DIRECTION AND PULL OUT. LIFT OUT TRIGGER GUARD GROUP (E). TURN RECOIL SPRING GUIDE (F) 90° TO RIGHT OR LEFT AND REMOVE GUIDE (F) AND SPRING (G).

DISMANTLING OF TRIGGER GUARD GROUP

13 REMOVE TWO SCREWS (A) AND LEFT PLATE (B). REMOVE TWO SCREWS (C) AND RIGHT PLATE (D).



14 DEPRESS EJECTOR LOCK (E). HOLD THUMB IN FRONT OF MAGAZINE CATCH SPRING (F) AND SLIDE EJECTOR (G) UPWARD AND OUT. REMOVE MAGAZINE CATCH SPRING (F). PUNCH OUT MAGAZINE CATCH PIN (H). LIFT OUT MAGAZINE CATCH (J) AND MAGAZINE RELEASE (K). PULL OUT EJECTOR LOCK (E) AND SPRING (L).

15 PLACE SCREWDRIVER UNDER SEAR SPRING (M) AND PULL UPWARD AND TO THE REAR OF TRIGGER GUARD. PUSH OUT TRIGGER PIN (N). REMOVE TRIGGER (P) AND CONNECTOR (Q) THROUGH TOP OF TRIGGER GUARD. PUSH OUT SEAR PIN (R). LIFT OUT SEAR (S) AND SEAR LEVER (T). PRY UP ON SEAR CARRIER (U) AND LIFT OUT. REMOVE C'RECOIL SPRING (V). PRY CHANGE LEVER SPRING (W) OUT OF SEAT AND REMOVE FROM REAR OF GUARD. PULL OUT CHANGE LEVER (X).

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 8 OF 13

REMOVAL OF HAMMER, OPERATING HANDLE AND SLIDE

(16) ALIGN HAMMER PIN (A) WITH HOLE (B) IN OPERATING HANDLE AND HOLE IN OPPOSITE SIDE OF RECEIVER. PUSH OUT HAMMER PIN (A). SLIDE OPERATING HANDLE (C) TO REAR AND OUT.

(17) SLIDE HAMMER (D) FORWARD AND LIFT OUT OF RECEIVER.

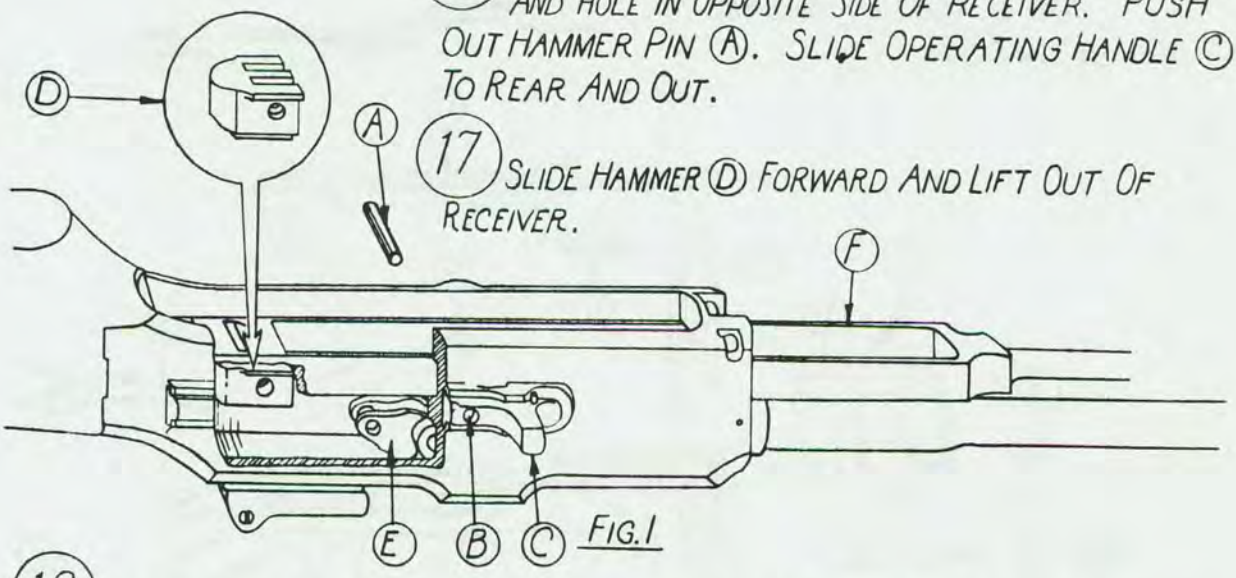


FIG. 1

(18) PRESS DOWN ON BOLT LINK (E) ALLOWING SLIDE (F) TO BE PULLED FORWARD AND OUT.

DISMANTLING OF OPERATING HANDLE AND SLIDE

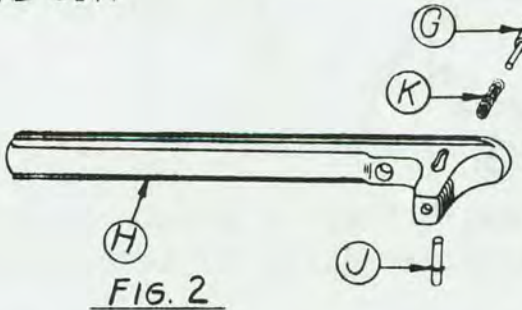


FIG. 2

(19) PRESS OPERATING HANDLE PLUNGER (G) INTO OPERATING HANDLE (H) AS FAR AS POSSIBLE. PUSH OUT OPERATING HANDLE PLUNGER PIN (J). REMOVE PLUNGER (G) AND SPRING (K).

(20) PUNCH OUT PIN (L). UNSCREW GAS PISTON (M) FROM SLIDE (N).

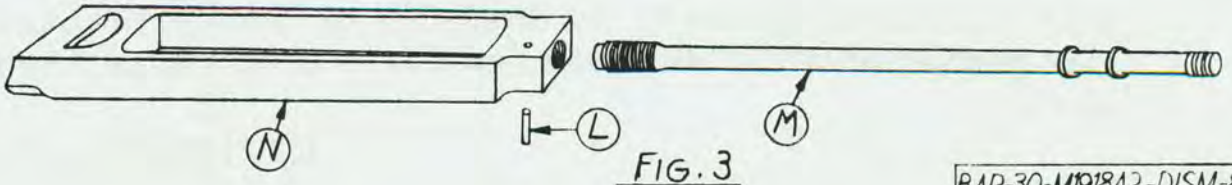


FIG. 3

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 9 OF 13

REMOVAL OF BOLT GROUP, BOLT GUIDE AND CHANGE LEVER STOP

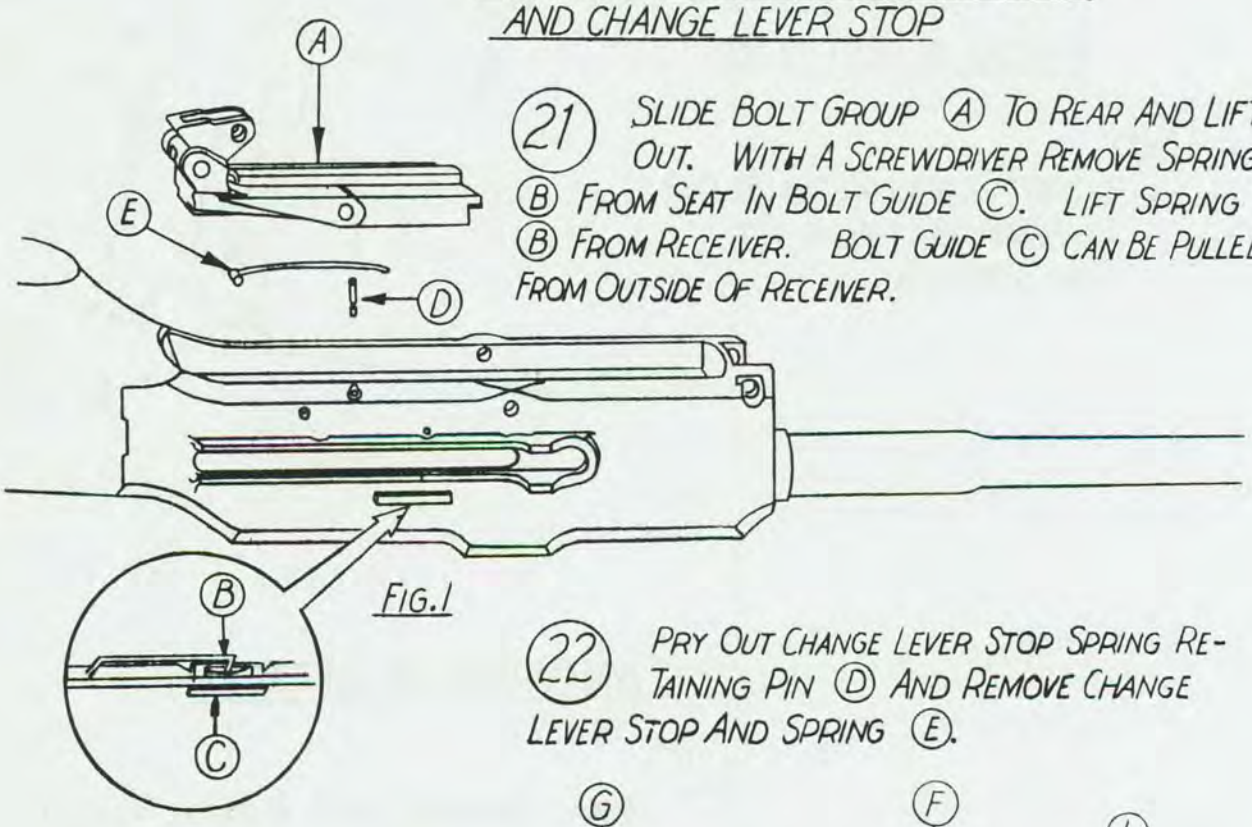


FIG. 1

(21) SLIDE BOLT GROUP (A) TO REAR AND LIFT OUT. WITH A SCREWDRIVER REMOVE SPRING (B) FROM SEAT IN BOLT GUIDE (C). LIFT SPRING (B) FROM RECEIVER. BOLT GUIDE (C) CAN BE PULLED FROM OUTSIDE OF RECEIVER.

(22) PRY OUT CHANGE LEVER STOP SPRING RETAINING PIN (D) AND REMOVE CHANGE LEVER STOP AND SPRING (E).

DISMANTLING OF BOLT GROUP

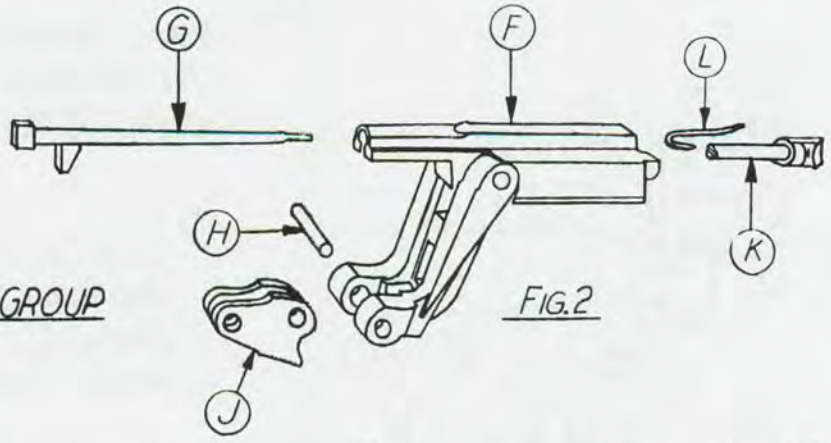


FIG. 2

(23) TO DISMANTLE BOLT AND BOLT LOCK GROUP (F), FIRST REMOVE FIRING PIN (G). PUNCH OUT PIN (H) AND REMOVE BOLT LINK (J). PLACE A SCREWDRIVER UNDER LIP OF EXTRACTOR (K) AND PRY OUTWARD AND TO THE REAR. REMOVE EXTRACTOR SPRING (L).

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 10 OF 13

REMOVAL OF BUTT PLATE

(24) EXTRACT SCREWS (A) AND (B), FIG. 1, AND REMOVE BUTT PLATE (C) FROM STOCK (D).

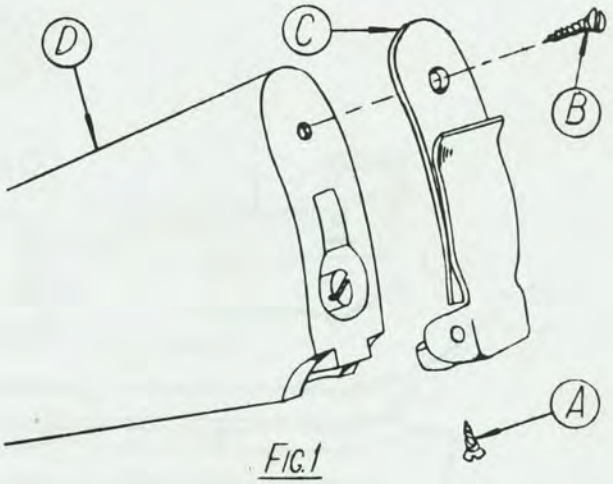


FIG. 1

DISMANTLING OF BUTT PLATE

(25) REMOVE SCREW (E), FIG. 2, THROUGH HOLE (F). TURN OVER BODY (G) AND ALLOW SPRING (H) AND BALL (J) TO FALL INTO THE HAND.

(26) DRIVE OUT PIN (K) AND SEPARATE BODY (G) AND PLATE (L). REMOVE SCREW (M) AND SPRING (N). DRIVE OUT PIN (P) AND REMOVE TRAP (Q).

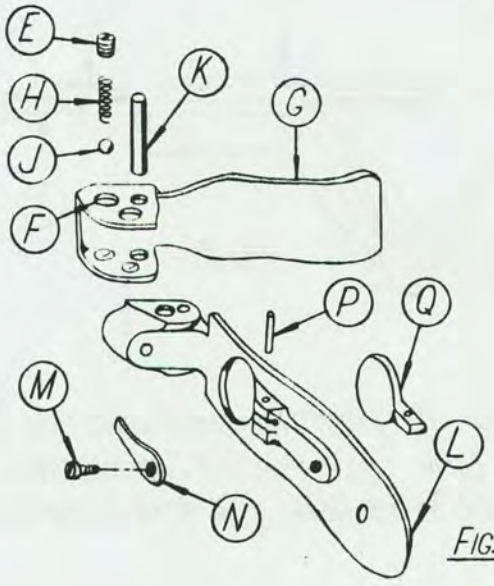
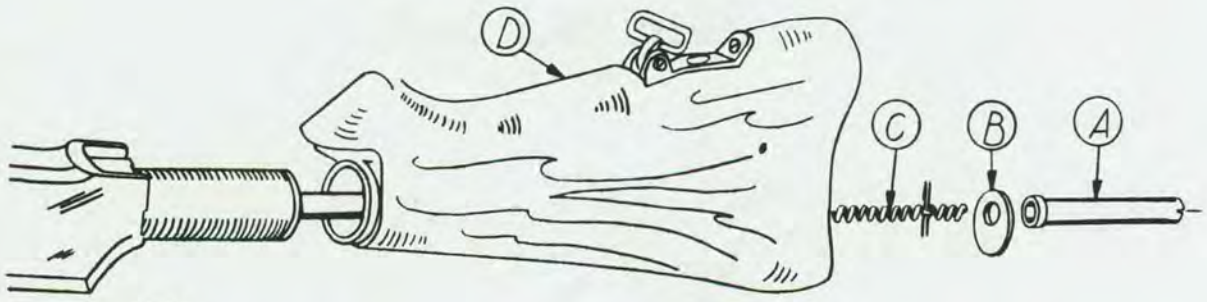


FIG. 2

SMALL ARMS RIFLE, AUTO. CAL. .30 BROWNING M1918 A2	DISMANTLING	SHEET 11 OF 13

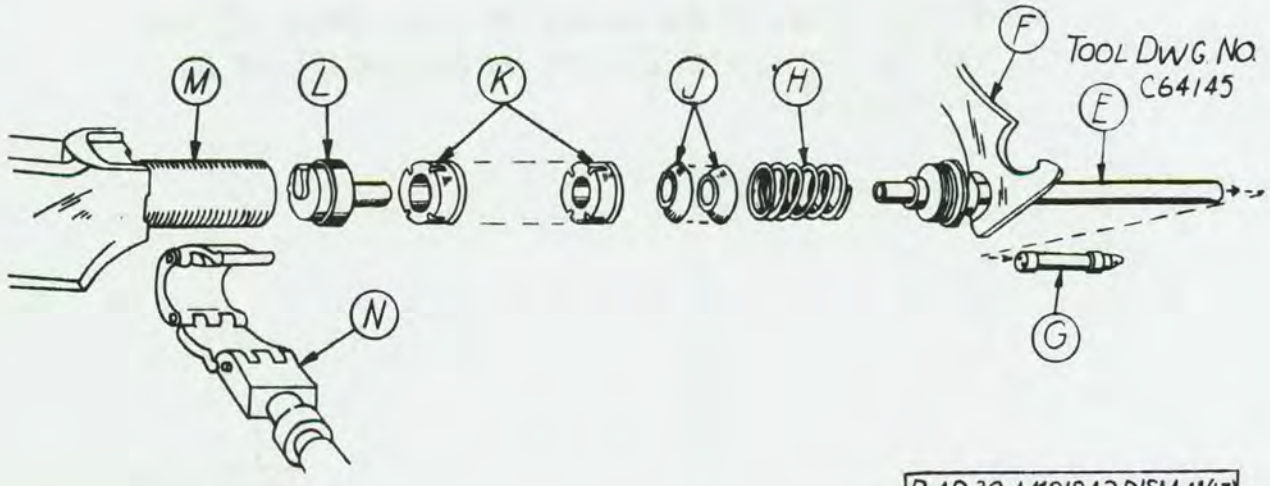
DISMANTLING OF BUFFER ASSEMBLY



(27) UNSCREW RETAINING SLEEVE (A), FIG. 1. REMOVE WASHER (B) AND DRAW OUT SPRING (C). PULL OFF STOCK (D).

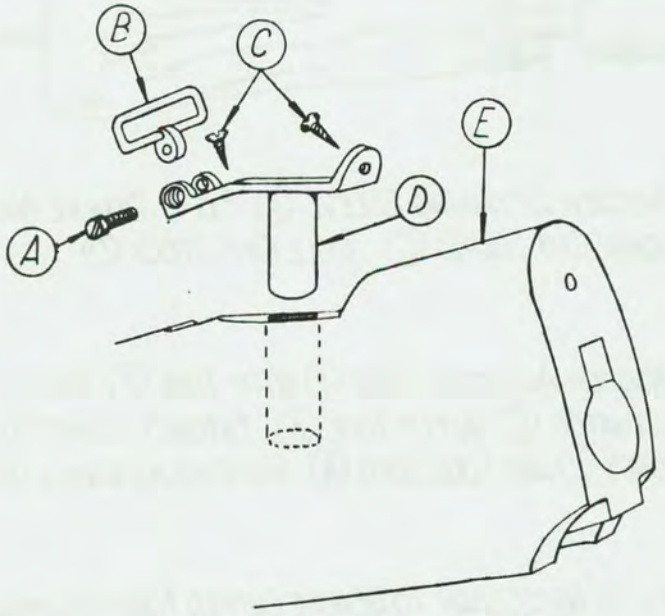
(28) UNSCREW ACTUATOR TUBE (E) WITH TOOL (F), FIG. 2. SLIDE ACTUATOR (G) OUT OF TUBE (E). EXTRACT SPRING (H); FOUR CONES (J) AND FOUR CUPS (K) AND HEAD ASSEMBLY (L).

(29) IF IT IS NECESSARY TO REMOVE BUFFER TUBE (M), UNSCREW IT WITH A WRENCH (N).



SMALL ARMS RIFLE, AUTO. CAL. .30 BROWNING M1918 A2	DISMANTLING	SHEET 12 OF 13

DISMANTLING OF SWIVEL



(30) EXTRACT SCREW (A) AND REMOVE THE SLING SWIVEL (B). TAKE OUT THE TWO SCREWS (C). LIFT THE BUSHING (D). OUT OF THE STOCK (E).

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918 A2	DISMANTLING	SHEET 13 OF 13

DISMANTLING OF BARREL

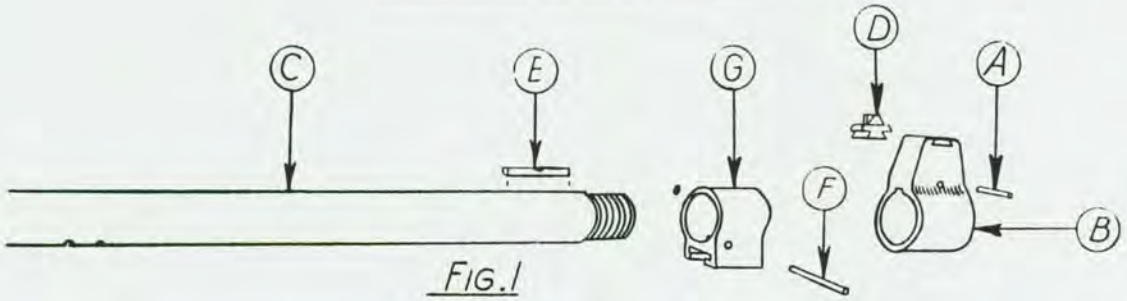


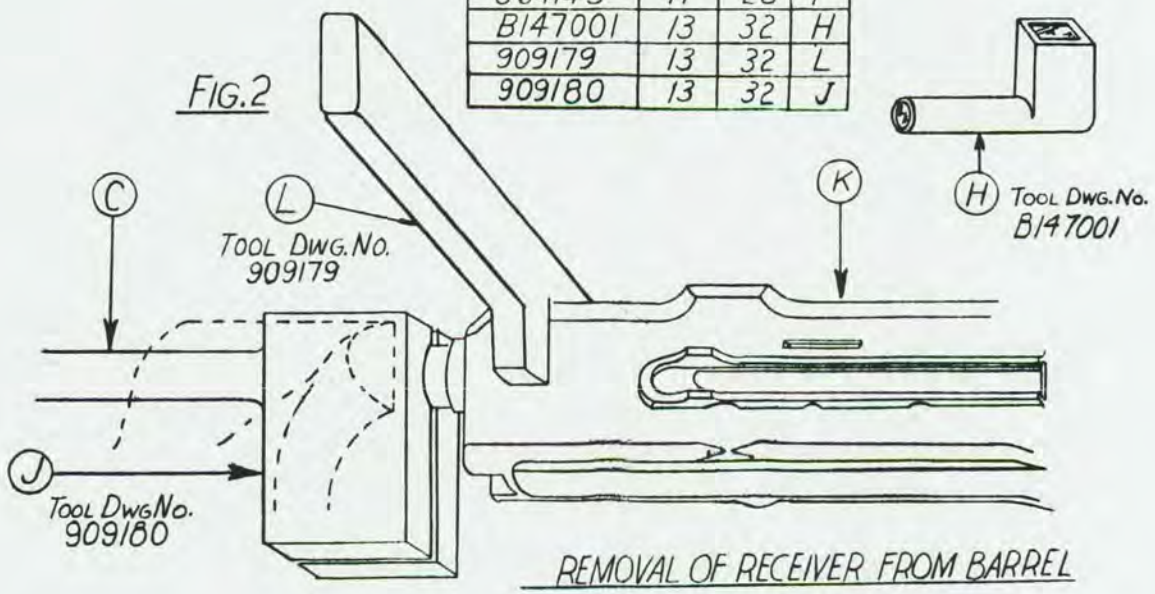
FIG. 1

(31) DRIVE OUT PIN (A), USING PIN PUNCH. TAP FRONT SIGHT BRACKET (B) FROM BARREL (C). TAP SIGHT (D) OUT OF BRACKET (B). REMOVE KEY (E) FROM BARREL. DRIVE OUT PIN (F), USING A PIN PUNCH. TAP BRACKET (G) FROM BARREL.

TOOLS REQUIRED

TOOL DWG. NO	SHEET	OPER.	DET.
C64145	11	28	F
B147001	13	32	H
909179	13	32	L
909180	13	32	J

FIG. 2



REMOVAL OF RECEIVER FROM BARREL

(32) INSERT TOOL (H) INTO BARREL FROM RECEIVER END AND INSPECT BARREL (C) FOR STRAIGHTNESS. CHECK BARREL FOR RUST, PITS AND BURRS. IF IT IS NECESSARY TO REPLACE THE BARREL, PLACE BARREL (C) IN FIXTURE (J). CLAMP FIXTURE (J) IN A VISE SHOWN BY DOTTED LINES. UNSCREW RECEIVER (K) FROM BARREL USING WRENCH (L).

ORDNANCE FIELD SERVICE

BASE SHOP DATA

Rifle, Auto., Cal. .30, Browning M1918A2

PREPARED UNDER THE DIRECTION OF THE
CHIEF OF ORDNANCE

ROCK ISLAND ARSENAL ; FEB.. 1943

B.S.D. No.

Assembly 2

SMALL ARMS RIFLE, AUTO. CAL. .30 BROWNING M1918A2	# ASSEMBLING	SHEET 1 OF 20

NOTE: CLEAN ALL PARTS IN SOLVENT SOLUTION AND DRY. EXAMINE EACH PART THOROUGHLY. REPLACE ANY PART EXCESSIVELY WORN OR BROKEN. BLACK-PENETRATE ALL METAL PARTS EXCEPT THE BOLT AND BOLT LINK, THE SLIDE AND PISTON ROD AND PIN, THE CONNECTOR SIGHT LEAF, HAMMER AND PIN, SPRING AND GUIDE, SEAR PIN AND CARRIER, AND BUFFER ASSEMBLY. LUBRICATE THOROUGHLY DURING ASSEMBLY.

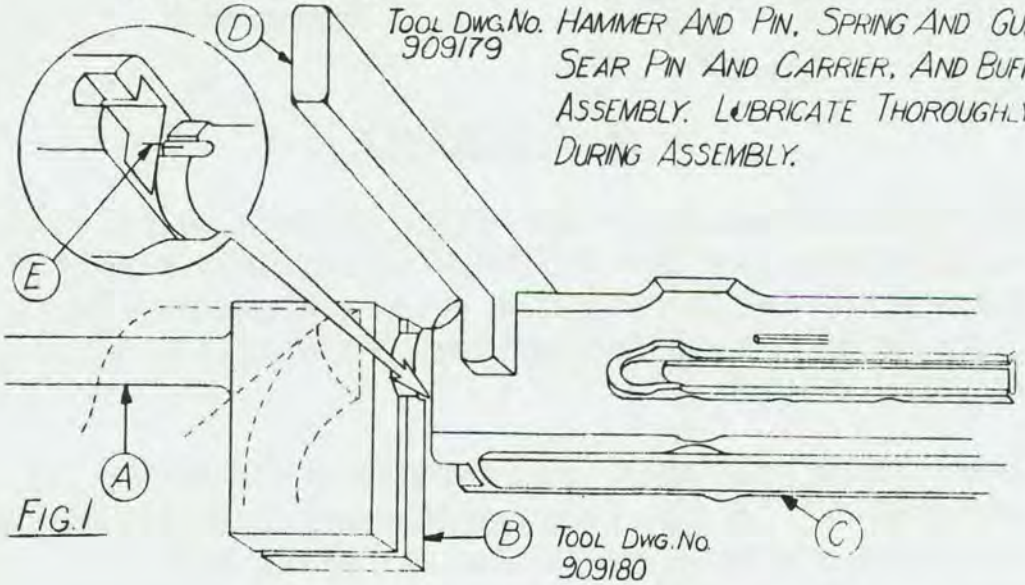


FIG. 1

ASSEMBLY OF RECEIVER TO BARREL

1. PLACE BARREL (A) IN FIXTURE (B). CLAMP FIXTURE (B) IN A VISE. SCREW RECEIVER (C) ON BARREL (A) WITH WRENCH (D). ALIGN LOCATION LINES AT (E).

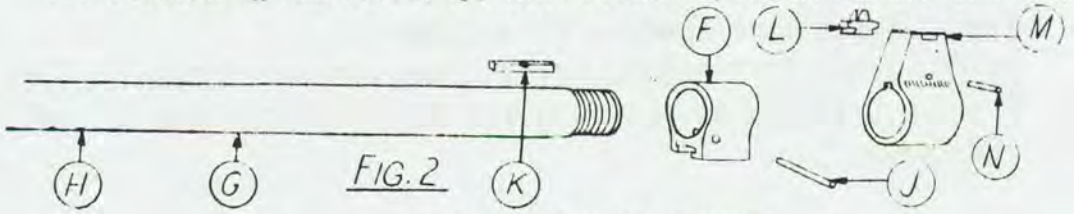


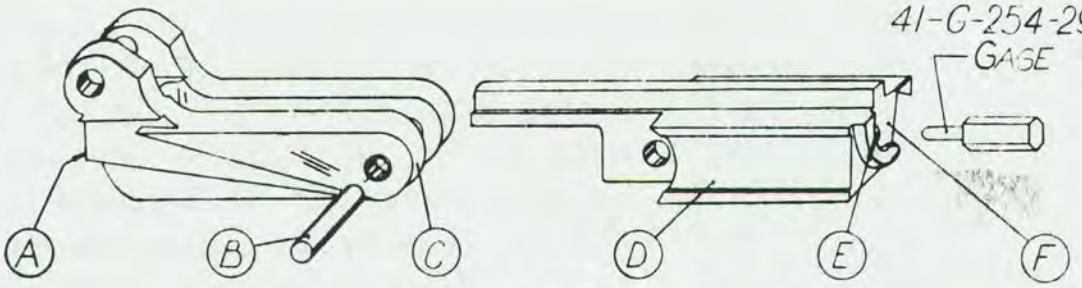
FIG. 2

ASSEMBLY OF BARREL

2. SLIDE BRACKET (F) ON BARREL (G) UNTIL GAS HOLE (H) IS ALIGNED WITH GAS HOLE IN BOTTOM OF BRACKET (F). TAP IN PIN (J).

3. INSERT KEY (K) IN BARREL (G). TAP SIGHT (L) IN SIGHT BASE (M). TAP SIGHT BASE (M) ON BARREL (G) UNTIL PIN (N) CAN BE DRIVEN THROUGH BRACKET (M) AND KEY (K).

SMALL ARMS RIFLE, AUTO CAL. .30 BROWNING M1918A2	ASSEMBLING	SHEET 2 OF 20

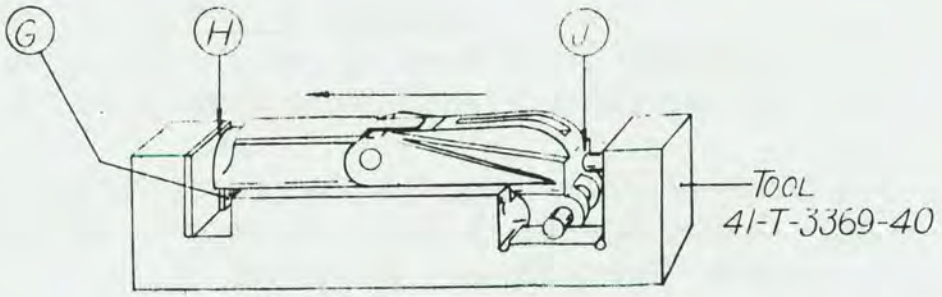


BOLT ASSEMBLY

(4) BOLT (D) IS UNSERVICEABLE IF FACE AT (F) IS SET BACK, THAT IS, SHOWS RECESSIVE WEAR, OR IF GAGE 41-G-254-295 ENTERS FIRING PIN HOLE (E). CHECK BOLT FOR EXCESSIVE SIDE PLAY AND LOOSENESS WITH BOLT LOCK. CHECK THE BOLT LOCK (C) FOR EXCESSIVE LOOSENESS ON PIN (B) OR RECESSIVE WEAR AT (A).

(5) CHECK THE BOLT ASSEMBLY (BOLT AND BOLT LOCK) INSIDE THE TOOL 41-T-3369-40. HOLD BOLT ASSEMBLY FORWARD AGAINST PAD (G). SPACE AT (J) SHOULD BE BETWEEN .010" AND .012". (SPACE AT (H) SHOULD BE BETWEEN .010" AND .014.") NEW OR SERVICEABLE BOLT (D) MAY OFTEN BE FITTED TO OLD BOLT LOCK (C), OR VICE VERSA, TO FORM A SERVICEABLE BOLT ASSEMBLY. BOLT ASSEMBLY IS HELD TOGETHER BY PIN (B) WHICH IS SLIGHTLY PEENED AT BOTH ENDS. ASSEMBLE THE BOLT AND BOLT LOCK SELECTIVELY UNTIL SERVICEABLE COMBINATION IS OBTAINED.

NOTE: IF THE BOLT AND BOLT LOCK COMBINATION IS TOO LONG, GRIND THE OVER-ALL LENGTH AS INSTRUCTED ON NEXT SHEET, IF THE EQUIPMENT IS AVAILABLE.



*REPLACES SHEET 2, B.S.D. UNIT NO. 2, ISSUE OF 3-5-43

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 3 OF 20

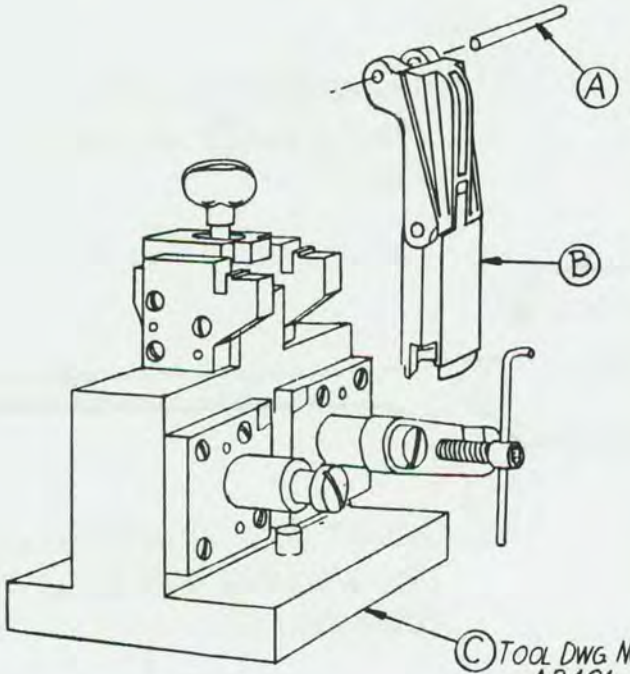


FIG. 1

6 PLACE PIN (A) IN THE BOLT AND BOLT LOCK ASSEMBLY (B) AS INDICATED. INSERT THE ASSEMBLY (B) IN FIXTURE (C).

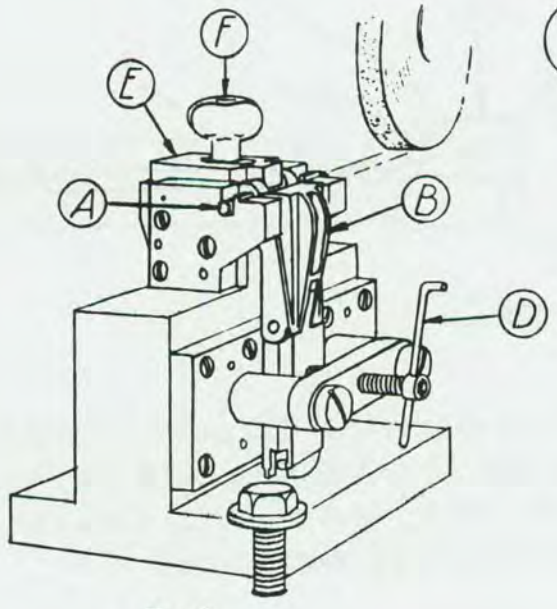


FIG. 2

7 IT IS IMPORTANT TO SECURE THE ASSEMBLY (B), FIG 2, WITH THE SCREW (D) FIRST. THEN PLACE PLATE (E) ON PIN (A) AS SHOWN AND SECURE WITH THUMB SCREW (F). GRIND OFF ONLY ENOUGH FOR BOLT ASSEMBLY (B) TO BE CORRECT, ACCORDING TO OPERATION 5.

SMALL ARMS. RIFLE, AUTO. CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 4 OF 20

ASSEMBLY FOR INSPECTION

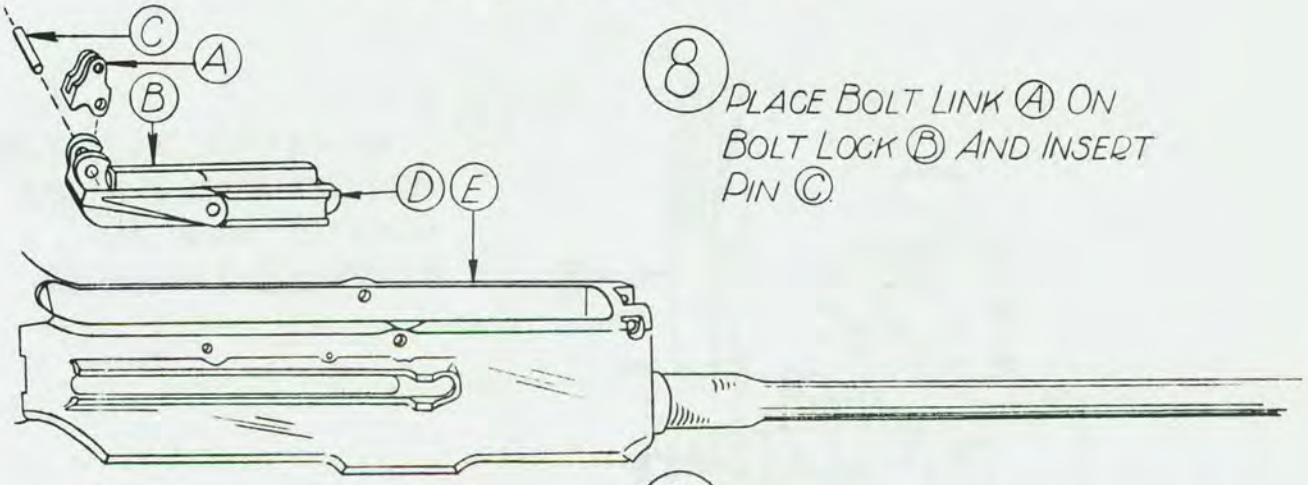


FIG. 1

8 PLACE BOLT LINK (A) ON BOLT LOCK (B) AND INSERT PIN (C).

9 INSERT BOLT (D) INTO RECEIVER (E) TOWARD REAR AND SLIDE IT FORWARD, FIG. 1.

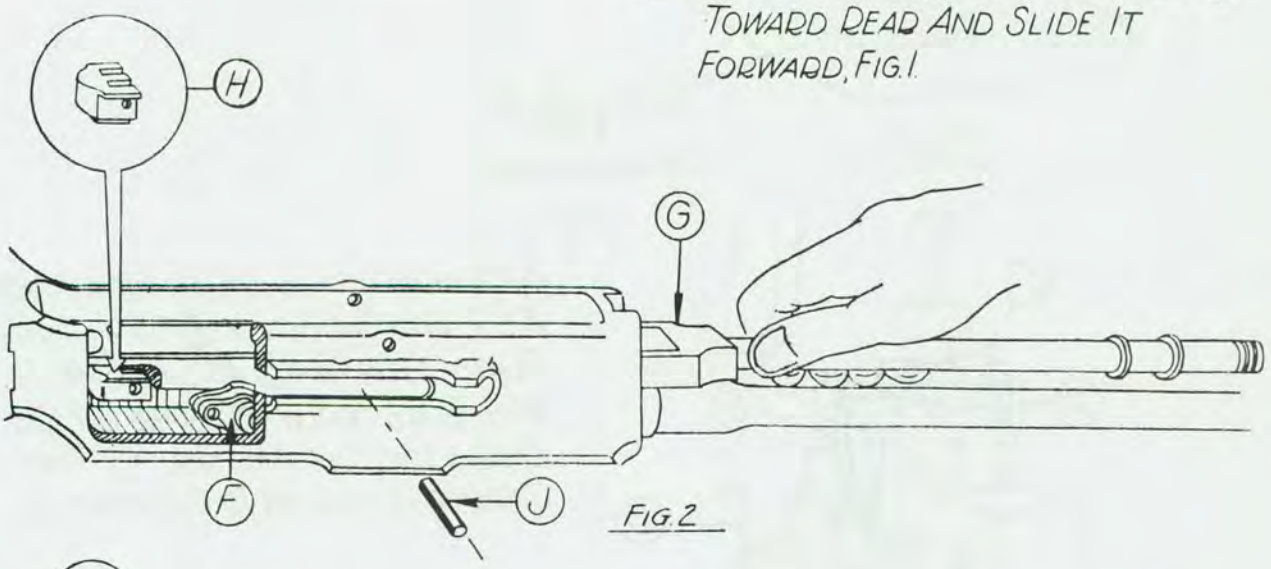


FIG. 2

10 PRESS DOWN BOLT LINK (F), FIG. 2, AND INSERT OPERATING SLIDE (G). SLIDE HAMMER (H) INTO UNDER SIDE OF OPERATING SLIDE (G) PULL SLIDE (G) FORWARD AND LIFT UP LINK (F) UNTIL PIN (J) CAN BE INSERTED THROUGH SLIDE (G), HAMMER (H) AND LINK (A).

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 5 OF 20

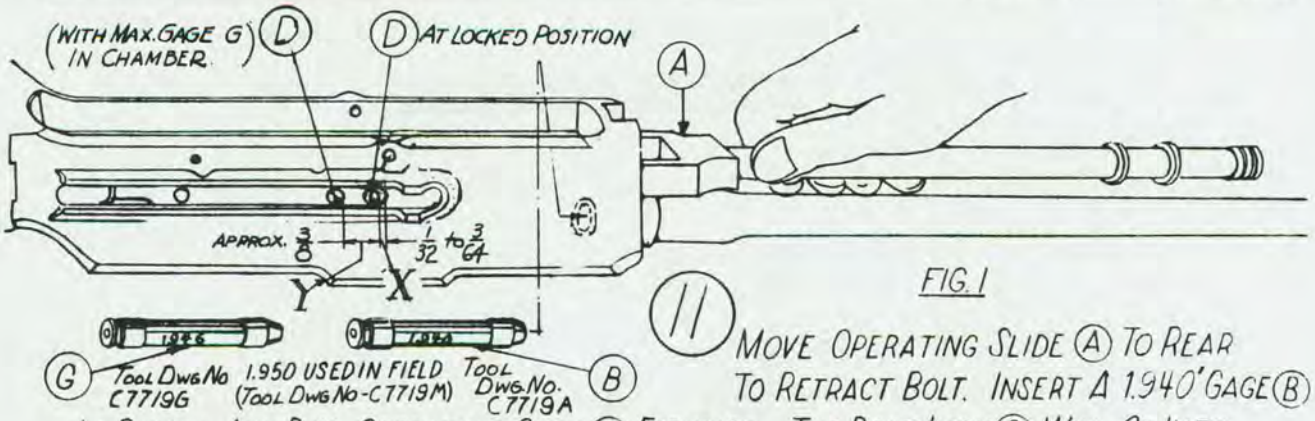


FIG. 1

11 MOVE OPERATING SLIDE (A) TO REAR TO RETRACT BOLT. INSERT A 1.940" GAGE (B) IN BARREL AND PULL OPERATING SLIDE (A) FORWARD. THE BOLT LOCK (C) WILL GO INTO POSITION, FIG. 2. HAMMER PIN (D) SHOULD STAND AT LOCKED POSITION **X**, FIG. 1. MOVE SLIDE (A) TO REAR TO RETRACT BOLT (F). PARTS SHOULD SLIDE EASILY. REMOVE GAGE (B).

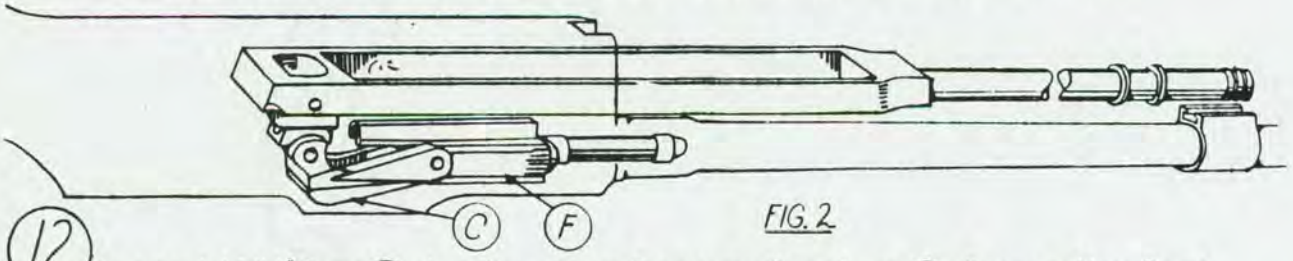


FIG. 2

12 INSERT A 1.946" GAGE (G) AND PULL SLIDE FORWARD. BOLT LOCK (C) SHOULD NOT DROP IN RECESS OF RECEIVER (H), FIG. 3. HAMMER PIN (D) SHOULD NOW STAND A DISTANCE **Y** (APPROX. 3/8 INCH) REARWARD OF ITS LOCKED POSITION **X**, FIG. 1. WHEN THE HEAD SPACE IS EXCESSIVE DUE TO WORN BOLT, BOLT LOCK, OR WORN RECESS IN RECEIVER, SELECTIVE FITS OF ANY OF THESE PARTS MAY BE TRIED IN AN EFFORT TO COMBINE A UNIT HAVING SATISFACTORY HEAD SPACE. MODIFIED BOLT LOCKS WHICH TAKE AN ADJUSTING PLATE MAY BE USED - SEE FIG. 4. THEY ARE GROUND TO SUIT IN JIG (C), SHEET 3.

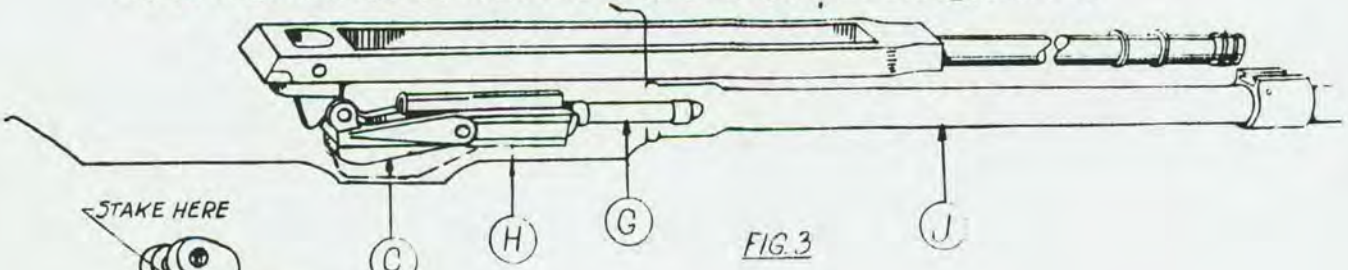
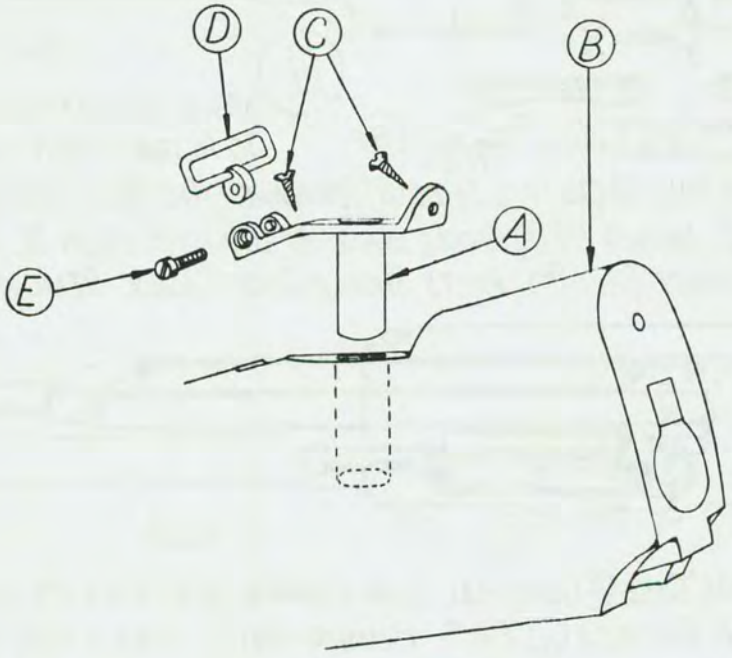


FIG. 3

FIG. 4

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 6 OF 20

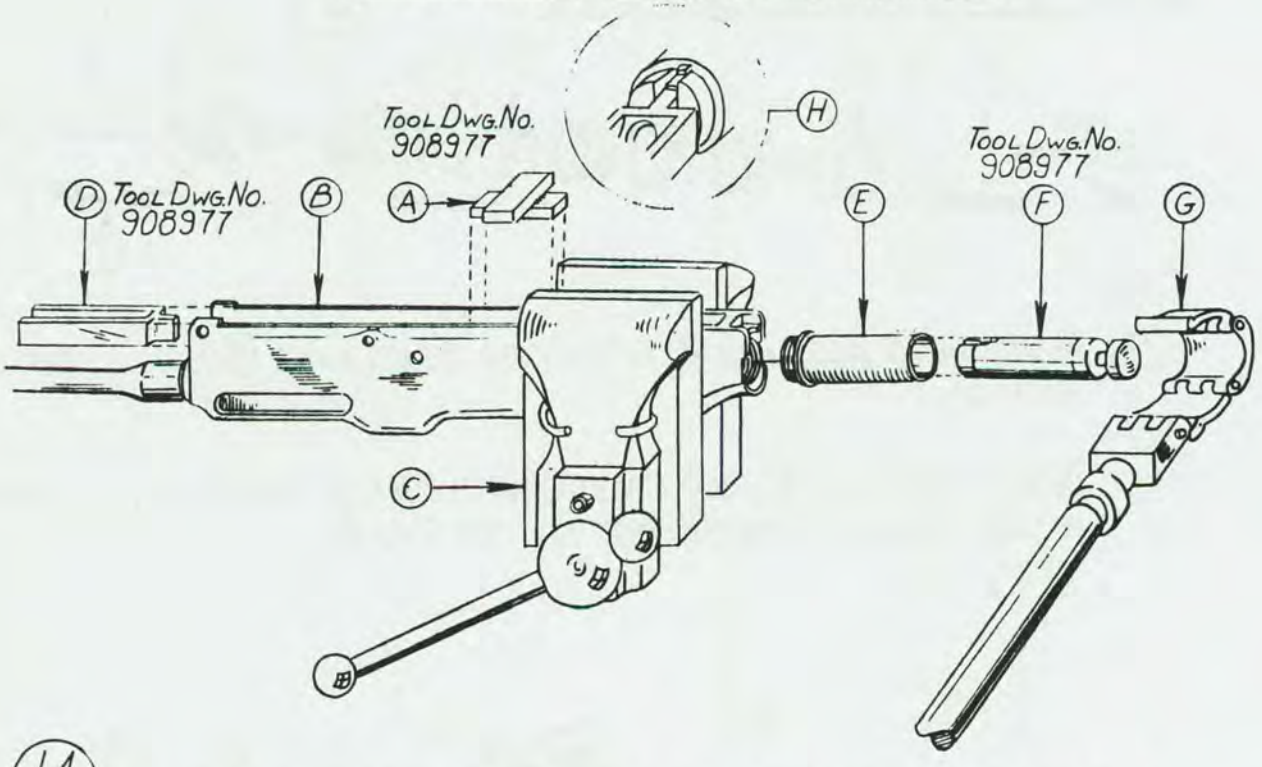
ASSEMBLY OF SWIVEL



(13) INSERT BUSHING (A) INTO POCKET IN STOCK (B) AS INDICATED. INSTALL SCREWS (C). ATTACH SWIVEL (D) BETWEEN LUGS WITH SCREW (E).

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 7 OF 20

ASSEMBLY OF BUFFER TUBE TO RECEIVER



(14) PLACE SAFETY FIXTURE (A) IN POSITION IN RECEIVER (B) AS INDICATED. THIS WILL PREVENT SQUEEZING RECEIVER (B) WHEN CLAMPED IN VISE (C).

(15) CLAMP RECEIVER IN VISE AS ILLUSTRATED, AND PLACE GAGE (D) IN RECEIVER (B).

(16) START BUFFER TUBE (E) INTO RECEIVER (B). INSERT GAGE (F) INTO BUFFER TUBE (E). TIGHTEN BUFFER TUBE WITH WRENCH (G) UNTIL GAGE (D) ENGAGES INTO GAGE (F) AS ILLUSTRATED IN INSET (H). TIGHTEN BUFFER TUBE TO THE TIGHTEST POSSIBLE POSITION AT WHICH THESE GAGES WILL ALIGN.

BUFFER TUBE ASSEMBLY INCLUDING STOCK

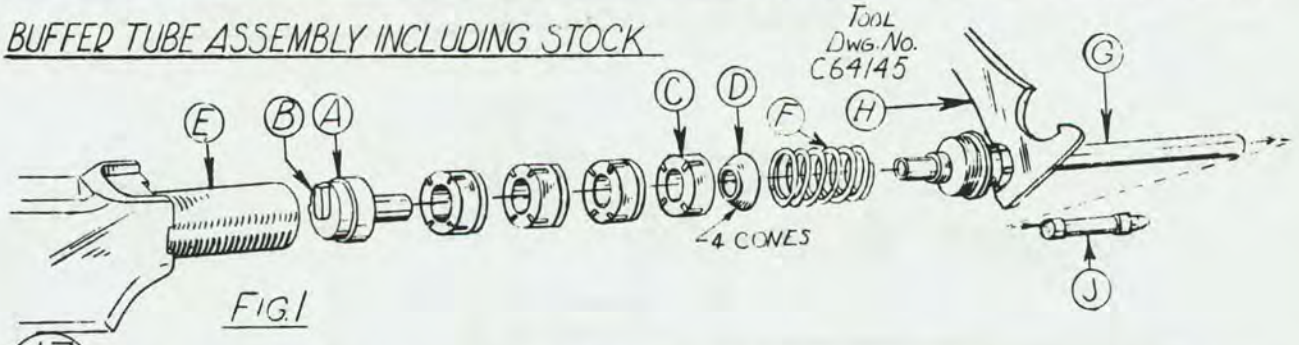


FIG. 1

17 PLACE HEAD ASSEMBLY Ⓐ IN POSITION SO RELEASE Ⓑ IS IN A VERTICAL POSITION.

18 INSERT FOUR CUPS Ⓒ, FOUR CONES Ⓓ INTO BUFFER TUBE Ⓔ AS ILLUSTRATED IN FIG. 1. PLACE SPRING Ⓕ INTO BUFFER TUBE Ⓔ.

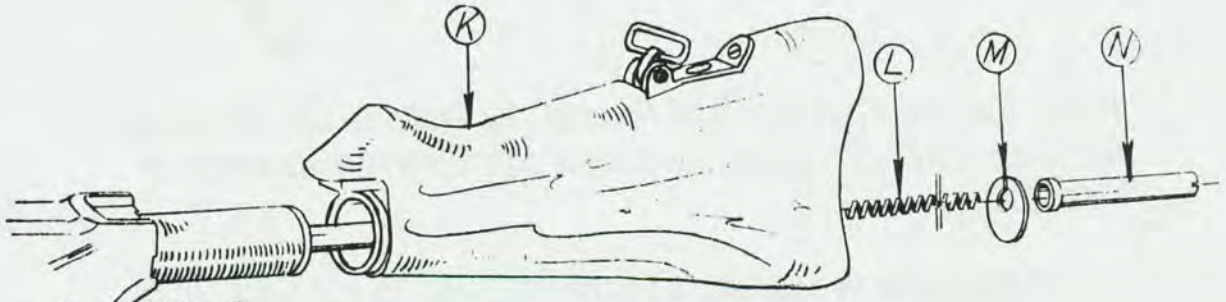


FIG. 2

19 SCREW ACTUATOR TUBE Ⓖ INTO BUFFER TUBE Ⓔ WITH TOOL Ⓗ. DIP ACTUATOR Ⓙ INTO LIGHT MACHINE OIL AND INSERT IT INTO ACTUATOR TUBE Ⓖ, FLAT END FIRST.

20 PLACE STOCK Ⓚ IN POSITION. INSERT ACTUATOR SPRING Ⓛ INTO ACTUATOR TUBE Ⓖ. PLACE LOCK WASHER Ⓜ IN STOCK Ⓚ AND SECURE STOCK Ⓚ IN POSITION WITH RETAINING SLEEVE Ⓝ.

SMALL ARMS RIFLE, AUTO CAL .30 BROWNING M1918A2	ASSEMBLING	SHEET 9 OF 20

ASSEMBLY OF BUTT PLATE

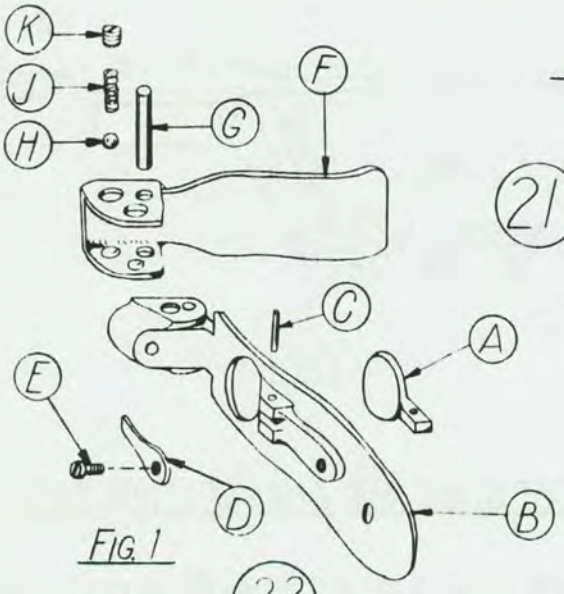


FIG. 1

21 INSTALL TRAP (A) IN PLATE (B) WITH PIN (C). SECURE TRAP SPRING (D) IN POSITION WITH SCREW (E).

22 PLACE BODY (F) ON PLATE (B) AND HINGE WITH PIN (G). INSERT BALL (H) AND SPRING (J). INSTALL SCREW (K). SCREWING IT DOWN UNTIL BODY (F) PASSES OVER IT FREELY.

23 ATTACH ASSEMBLED PLATE (B) TO BUTT STOCK (L) WITH TWO SCREWS (M) AND (N).

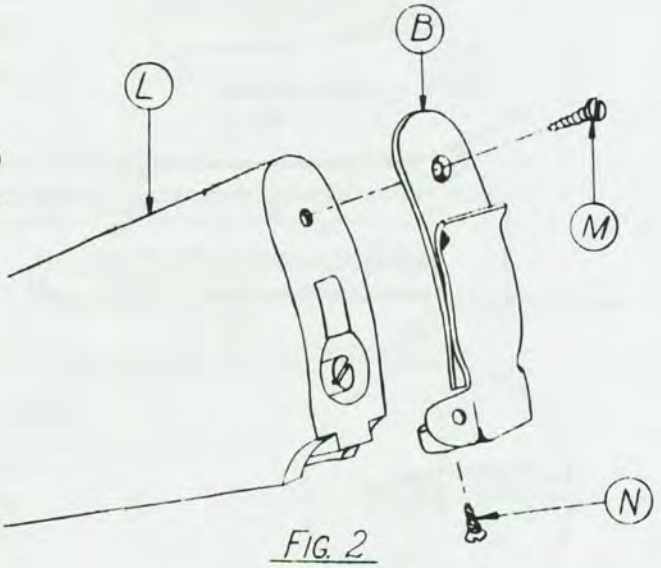


FIG. 2

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 10 OF 20

ASSEMBLY OF BOLT GROUP

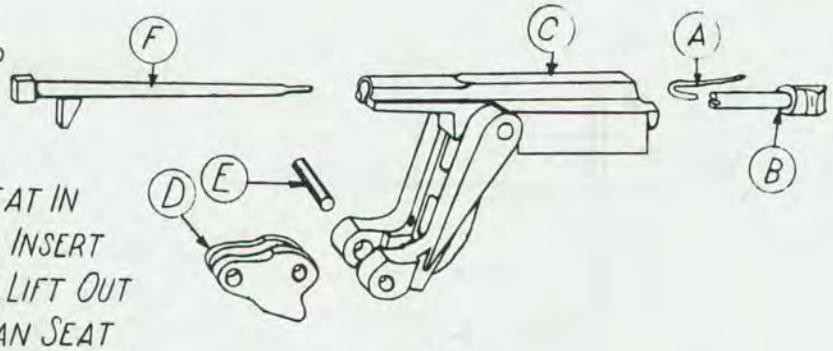


FIG. 1

(24) PLACE SPRING (A) IN ITS SEAT IN EXTRACTOR (B) AS SHOWN. INSERT EXTRACTOR INTO BOLT (C). LIFT OUT SO LUG ON EXTRACTOR CAN SEAT IN BOLT. PLACE LINK (D) IN POSITION AND PUSH PIN (E). INSERT FIRING PIN (F).

INSTALLATION OF BOLT GROUP, BOLT GUIDE AND CHANGE LEVER STOP

(25) INSERT BOLT GUIDE (G) IN HOUSING. SLIDE LONG END OF SPRING (H) IN HOLE FOR SAME, INSIDE OF RECEIVER. PRESSING AGAINST OUTSIDE OF BOLT GUIDE (G) AND USING SCREWDRIVER ON SPRING (H), FORCE THE SMALL END OF SPRING (H) IN ITS SEAT IN BOLT GUIDE (G).

(26) INSERT CHANGE LEVER STOP (J) AS SHOWN. WITH A SHARP INSTRUMENT, PRESS SPRING (K) AGAINST WALL OF RECEIVER UNTIL RETAINING PIN (L), WHEN INSERTED, WILL HOLD SPRING IN POSITION.

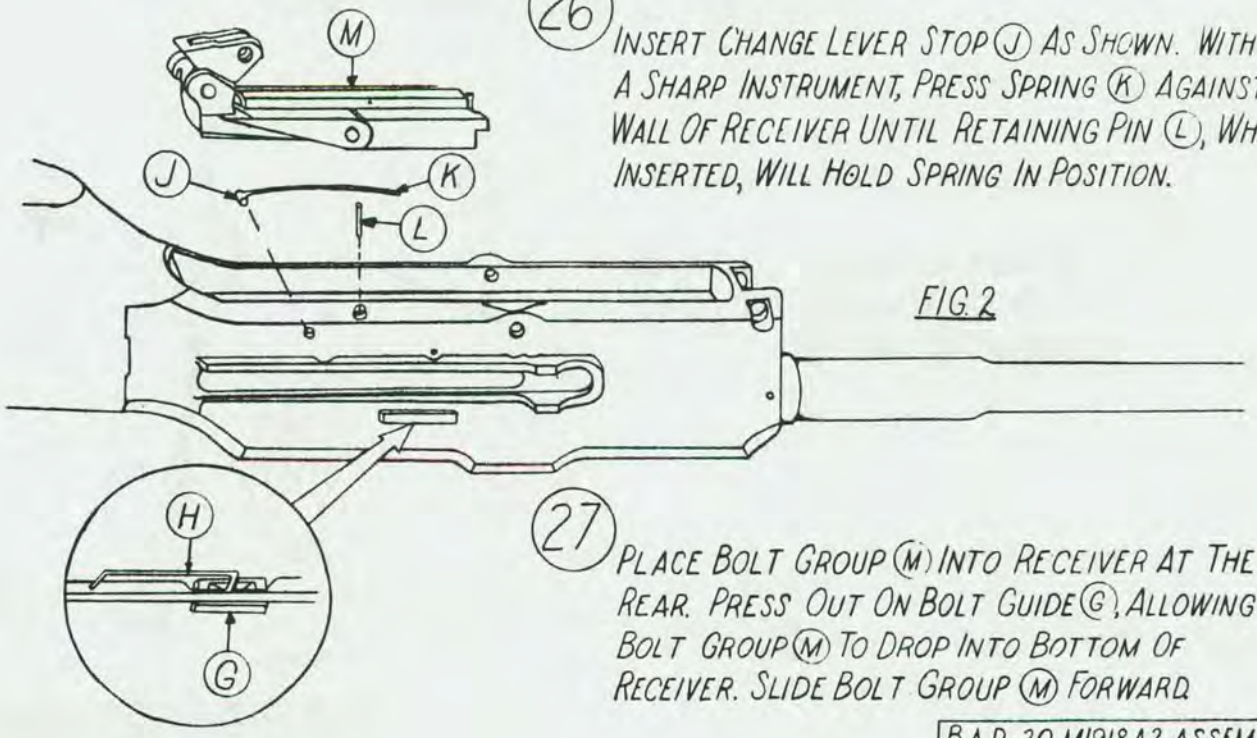


FIG. 2

(27) PLACE BOLT GROUP (M) INTO RECEIVER AT THE REAR. PRESS OUT ON BOLT GUIDE (G), ALLOWING BOLT GROUP (M) TO DROP INTO BOTTOM OF RECEIVER. SLIDE BOLT GROUP (M) FORWARD.

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 11 OF 20

TOOL DWG. NO. A77201

ASSEMBLY OF SLIDE AND OPERATING HANDLE

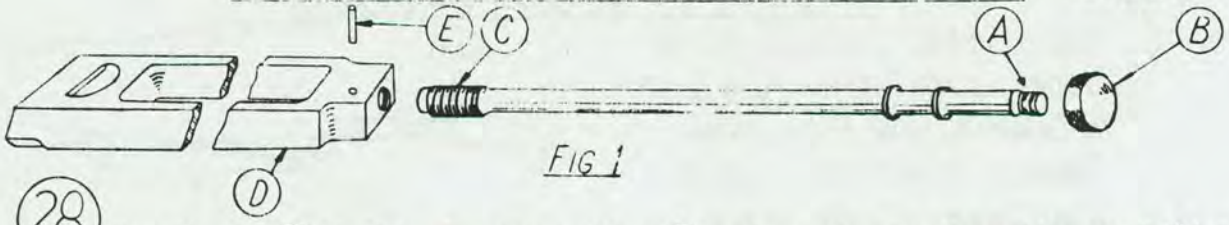


FIG 1

(28) TRY PISTON (A), FIG 1, IN THE RING GAGE (B). OPEN END OF GAGE HAS 0.494" INCH DIAMETER. IF PISTON ENTERS GAGE, IT IS NOT SERVICEABLE. REPLACE WITH NEW PISTON.

SCREW PISTON ROD (C) INTO SLIDE (D) AS FAR AS POSSIBLE BY HAND. UNSCREW ROD (C) TWO COMPLETE REVOLUTIONS AND TAP IN PIN (E).

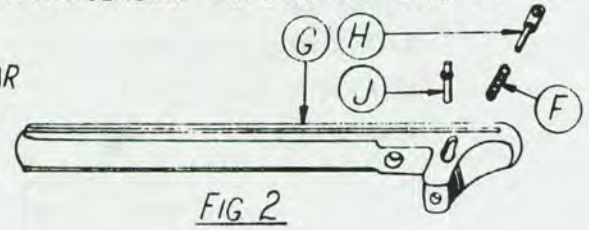


FIG 2

(29) INSERT SPRING (F) IN OPERATING HANDLE (G), FIG 2. WITH COUNTERSUNK SIDE OF HOLE UPWARD, INSERT PLUNGER (H), DEPRESSING SPRING (F) UNTIL PIN (J) CAN BE INSERTED.

INSTALLATION OF OPERATING HANDLE, SLIDE AND HAMMER

(30) SLIDE OPERATING HANDLE (G), FIG 3, INTO RECEIVER TO FORWARD POSITION. INSERT SLIDE (K) FROM FRONT OF RECEIVER, SLIDING IT TO REAR. SLIDE HAMMER (L) INTO SLIDE (K). PULL SLIDE (K) FORWARD AND ALIGN HOLES (M) IN BOLT LINK WITH HOLES IN HAMMER (L) AND HOLE IN RECEIVER. INSERT PIN (N) AND PUSH IT IN UNTIL IT CLEARS THE WALL OF RECEIVER.

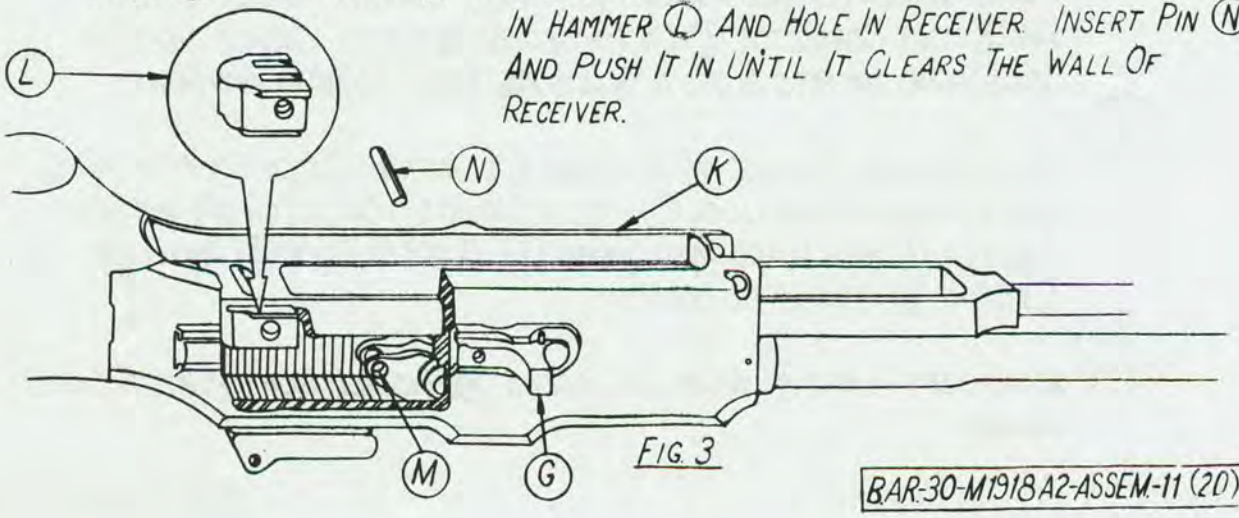
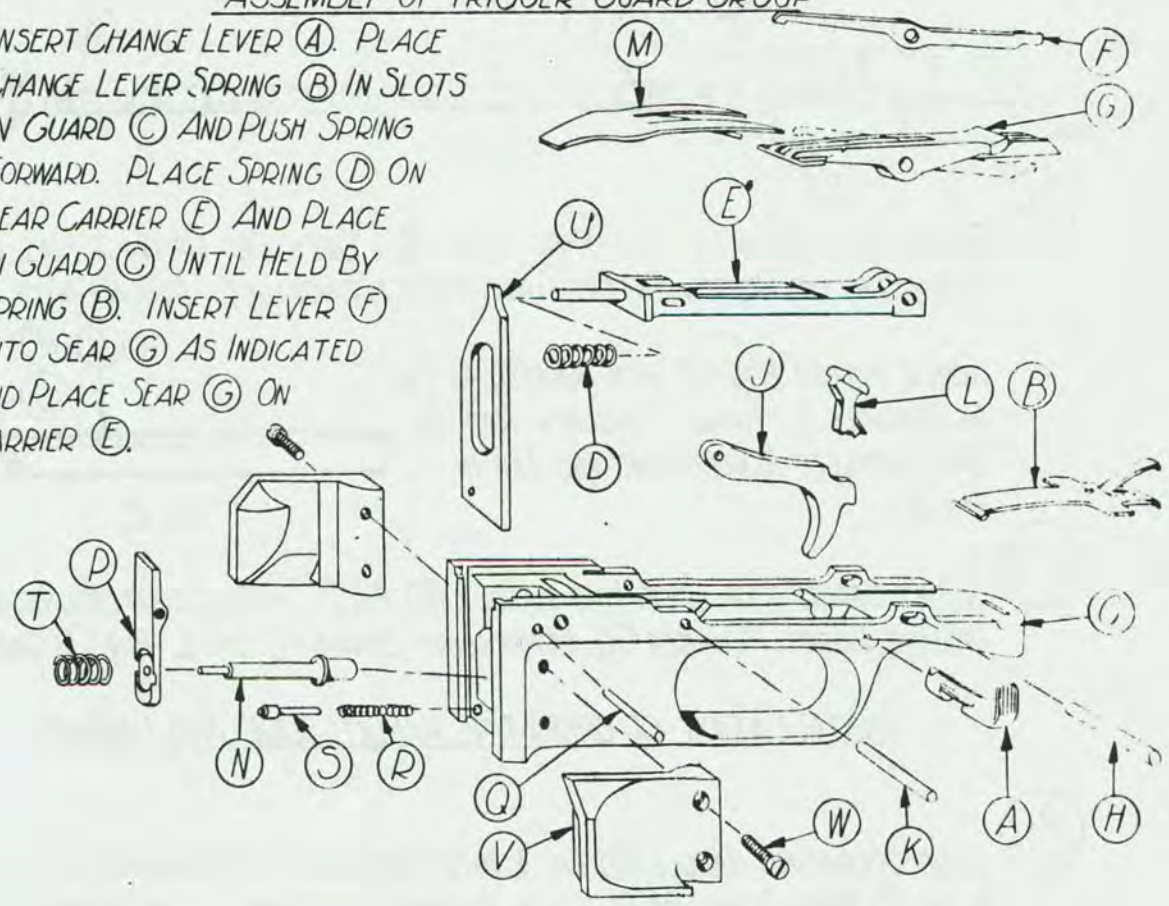


FIG. 3

SMALL ARMS RIFLE, AUTO, CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 12 OF 20

ASSEMBLY OF TRIGGER GUARD GROUP

(31) INSERT CHANGE LEVER (A). PLACE CHANGE LEVER SPRING (B) IN SLOTS IN GUARD (C) AND PUSH SPRING FORWARD. PLACE SPRING (D) ON SEAR CARRIER (E) AND PLACE IN GUARD (C) UNTIL HELD BY SPRING (B). INSERT LEVER (F) INTO SEAR (G) AS INDICATED AND PLACE SEAR (G) ON CARRIER (E).



PRESS CARRIER FORWARD AND INSTALL PIN (H). INSTALL TRIGGER (I) WITH PIN (K). SET CONNECTOR (L) ON TRIGGER AS INDICATED. ENGAGE SIDES OF SEAR SPRING (M) INTO SLOTS IN GUARD AND PRESS FORWARD AND DOWN.

(32) SLIDE MAGAZINE RELEASE (N) IN GUARD (C). INSTALL CATCH (P) WITH PIN (Q). INSERT SPRING (R) AND LOCK (S). HOLD SPRING (T) ON CATCH (P) AND SLIDE EJECTOR (U) INTO GUARD OVER SPRING (T). DEPRESS LOCK (S) AND SLIDE EJECTOR (U) DOWN UNTIL LOCKED.

(33) INSTALL LEFT PLATE (V) WITH TWO SCREWS (W). INSTALL RIGHT PLATE IN SAME MANNER.

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 13 OF 20

INSTALLATION OF SPRING, GUIDE AND TRIGGER GUARD GROUP

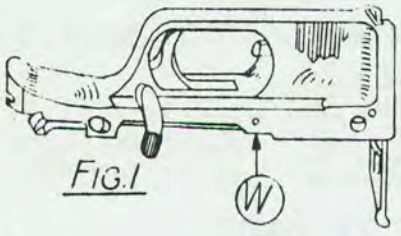


FIG. 1

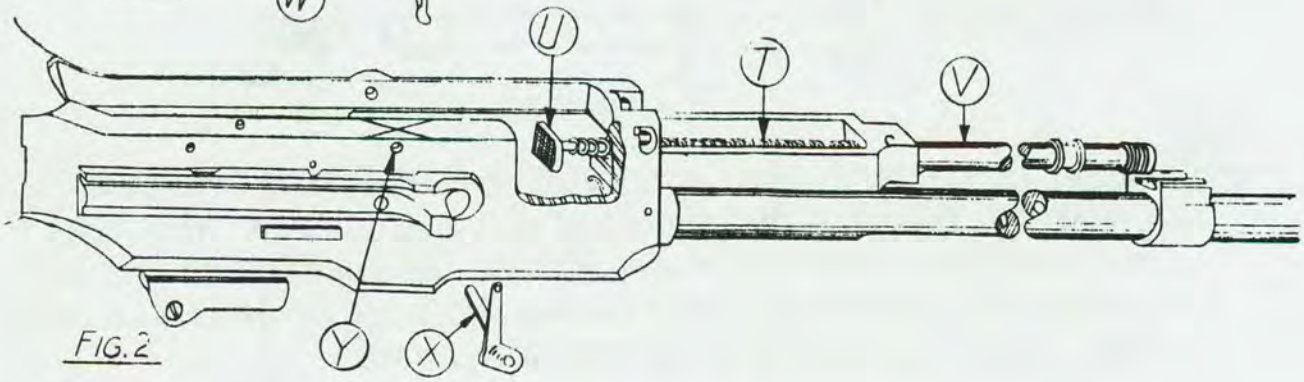


FIG. 2

(34) MEASURE SPRING (T). IT SHOULD BE 15 INCHES LONG, FREE HEIGHT. REPLACE IF NECESSARY.

(35) INSERT THE SPRING AND GUIDE (U) THROUGH THE RECEIVER INTO THE PISTON ROD (V). COMPRESS SPRING (T) BY PUSHING IN GUIDE (U) UNTIL GUIDE CAN BE TURNED 90° AND PROPERLY SEATED.

(36) PLACE TRIGGER GUARD (W) INTO RECEIVER AND INSERT PIN (X) AT (Y). TURN PIN (X) 90° IN A COUNTER-CLOCKWISE DIRECTION UNTIL PROPERLY SEATED.

ASSEMBLY OF FOREARM AND TUBE

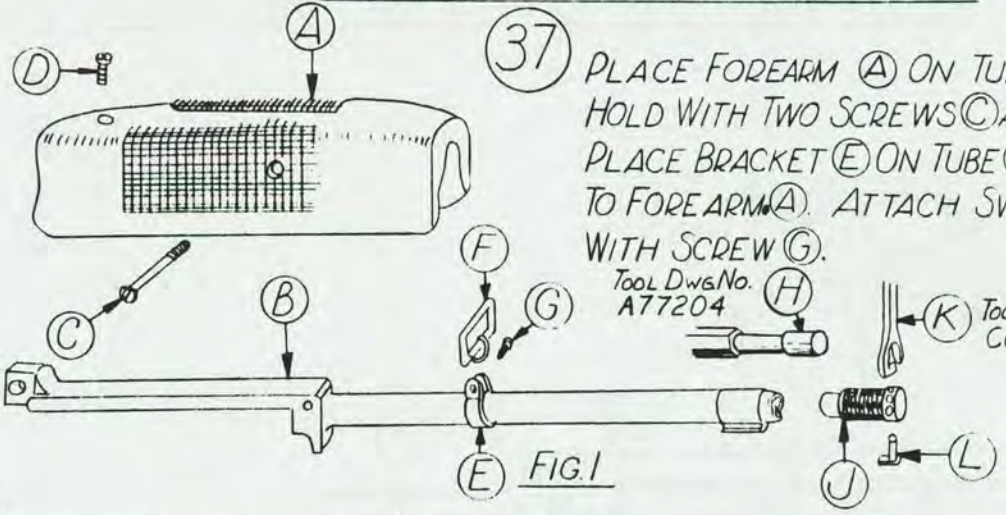


FIG. 1

37 PLACE FOREARM (A) ON TUBE (B) AND HOLD WITH TWO SCREWS (C) AND (D). PLACE BRACKET (E) ON TUBE (B) NEXT TO FOREARM (A). ATTACH SWIVEL (F) WITH SCREW (G).

38 INSERT PLUG GAGE (H) INTO CYLINDER (J). IF PLUG ENTERS CYLINDER, THE CYLINDER IS OVERSIZE AND SHOULD BE REPLACED. SCREW CYLINDER (J) INTO TUBE (B) WITH COMBINATION TOOL (K) UNTIL SHOULDER OF GAS CYLINDER IS ABOUT ONE TURN FROM CORRESPONDING SHOULDER OF THE GAS CYLINDER TUBE. LOCK CYLINDER (J) IN POSITION WITH LOCK (L).

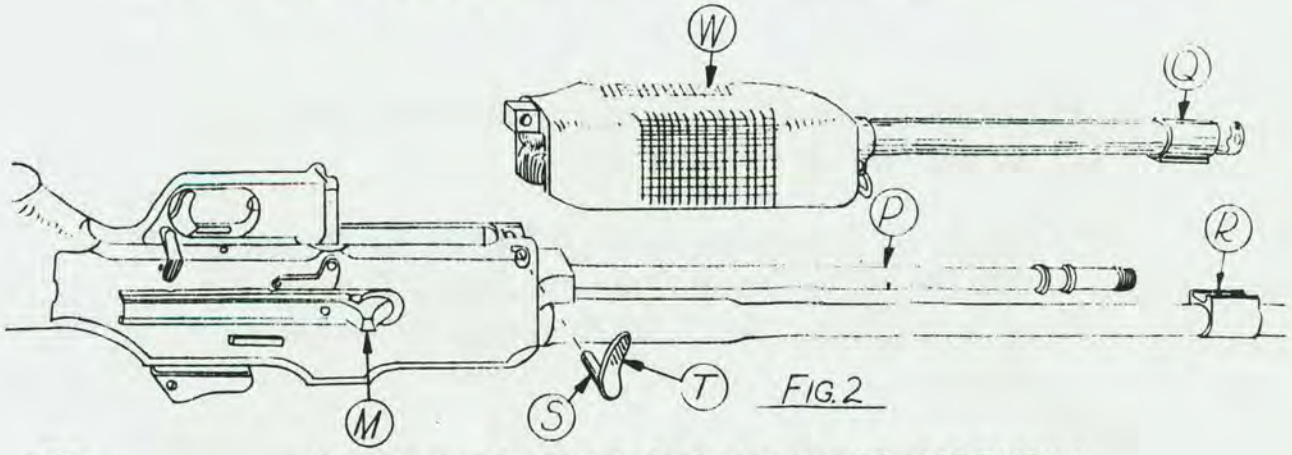


FIG. 2

INSTALLATION OF GAS CYLINDER ASSEMBLY

39 COCK THE GUN BY RETRACTING OPERATING HANDLE (M) AND RETURNING IT TO FORWARD POSITION. SLIDE GAS CYLINDER ASSEMBLY (W) OVER PISTON ROD (P) BEING SURE MALE BRACKET (Q) ENGAGES FEMALE BRACKET (R). INSERT PIN (S) AND TURN SPRING (T) 180° COUNTER-CLOCKWISE UNTIL IT IS SEATED IN RECEIVER.

SMALL ARMS RIFLE, AUTO CAL .30 BROWNING M1918 A2	ASSEMBLING	SHEET 15 OF 20

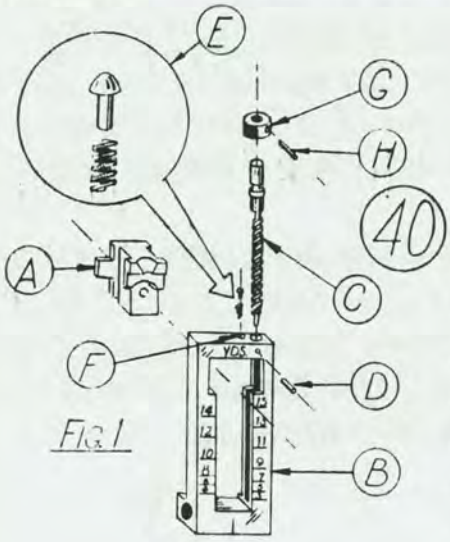


FIG 1

ASSEMBLY OF REAR SIGHT

PLACE SLIDE (A), FIG. 1, IN POSITION IN LEAF (B) AND SCREW ELEVATING SCREW (C) INTO LEAF (B). SECURE ELEVATING SCREW (C) WITH PIN (D). DROP SPRING AND PLUNGER (E) INTO HOLE (F) AND PLACE KNOB (G) ON ELEVATING SCREW (C). ALIGN THE TWO HOLES AND TAP PIN (H) INTO POSITION.

41 IF A NEW ELEVATING SCREW (C) IS USED, IT WILL BE NECESSARY TO PLACE ASSEMBLED LEAF (J), FIG. 2, IN FIXTURE (K) AND DRILL A HOLE IN ELEVATING SCREW (C) TO ACCOMMODATE PIN (H).

42 SECURE WINDAGE SCALE (L), FIG. 3, TO BASE (M) WITH TWO SCREWS (N).

ENGAGE SPRING (P) IN THE SLOT IN BASE (M) AND TAP INTO POSITION WITH A DRIFT AND A HAMMER.

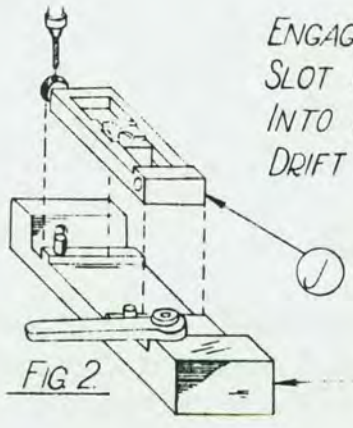


FIG 2

K TOOL DWG. NO. 908981

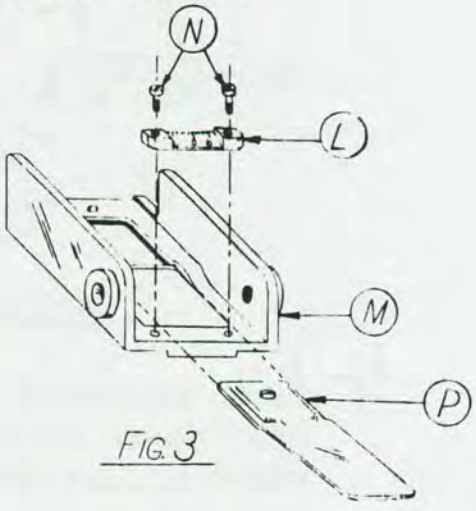


FIG 3

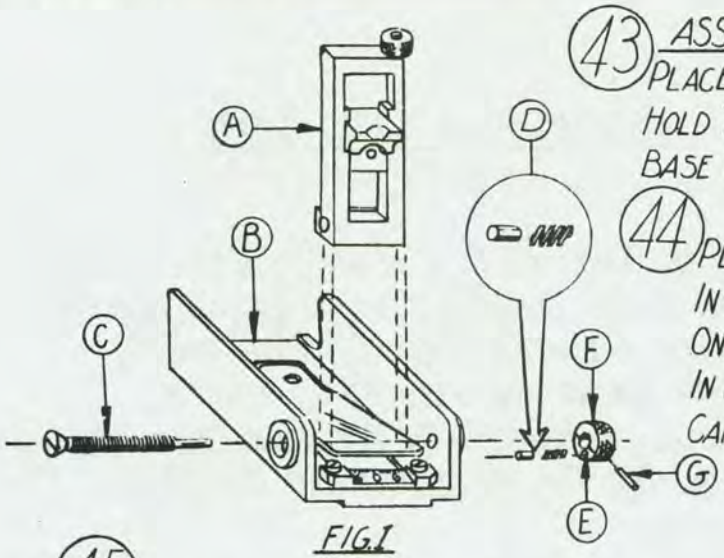


FIG. 1

(43) ASSEMBLY OF REAR SIGHT (CONTD)

PLACE LEAF ASSEMBLY (A) ON BASE (B), FIG 1. HOLD THE LEAF (A) IN CORRECT ALIGNMENT WITH BASE (B) AND SCREW IN WINDAGE SCREW (C).

(44) PLACE SPRING AND PLUNGER (D) IN POSITION IN HOLE (E) OF KNOB (F). PLACE KNOB (F) ON WINDAGE SCREW (C). ALIGN THE HOLES IN KNOB (F) AND WINDAGE SCREW (C) SO PIN (G) CAN BE TAPPED INTO PLACE.

(45) IF A NEW WINDAGE SCREW (C) IS USED, A HOLE MUST BE DRILLED IN THE WINDAGE SCREW TO ACCOMMODATE THE PIN (G).

(46) PLACE REAR SIGHT (H), FIG. 2, IN POSITION IN FIXTURE (J) AS ILLUSTRATED. PULL LEVER (K) AROUND TO THE RIGHT TO SECURE.

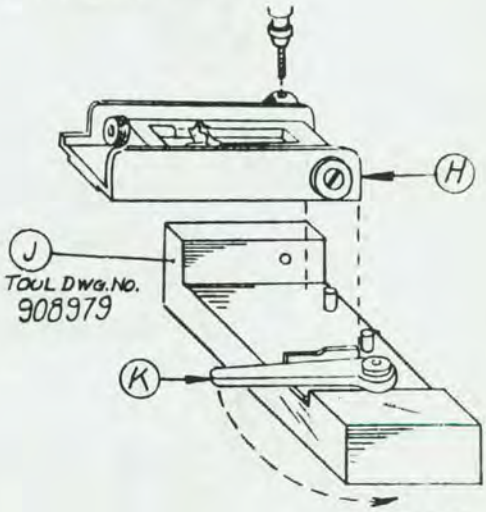


FIG. 2

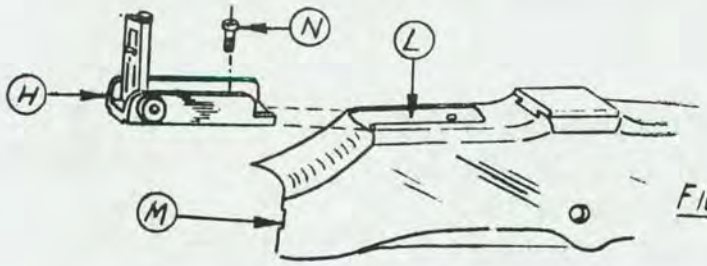


FIG. 3

ASSEMBLY OF REAR SIGHT TO GUN

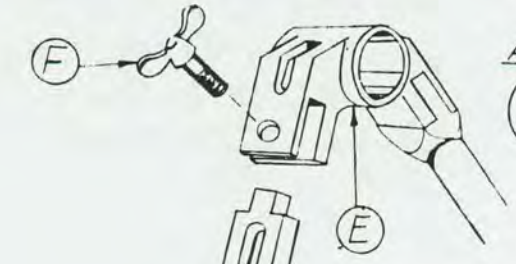
(47) ENGAGE REAR SIGHT (H), FIG. 3, INTO KEYWAY (L) ON RECEIVER (M). TAP REAR SIGHT WITH A HAMMER AND A BRASS FLATTER UNTIL CORRECT ALIGNMENT IS ACQUIRED, PERMITTING SCREW (N) TO BE SCREWED THROUGH SIGHT (H) INTO RECEIVER (M).

SMALL ARMS RIFLE, AUTO. CAL. 30 BROWNING M1918A2	ASSEMBLING	SHEET 17 OF 20

ASSEMBLY OF BIPOD

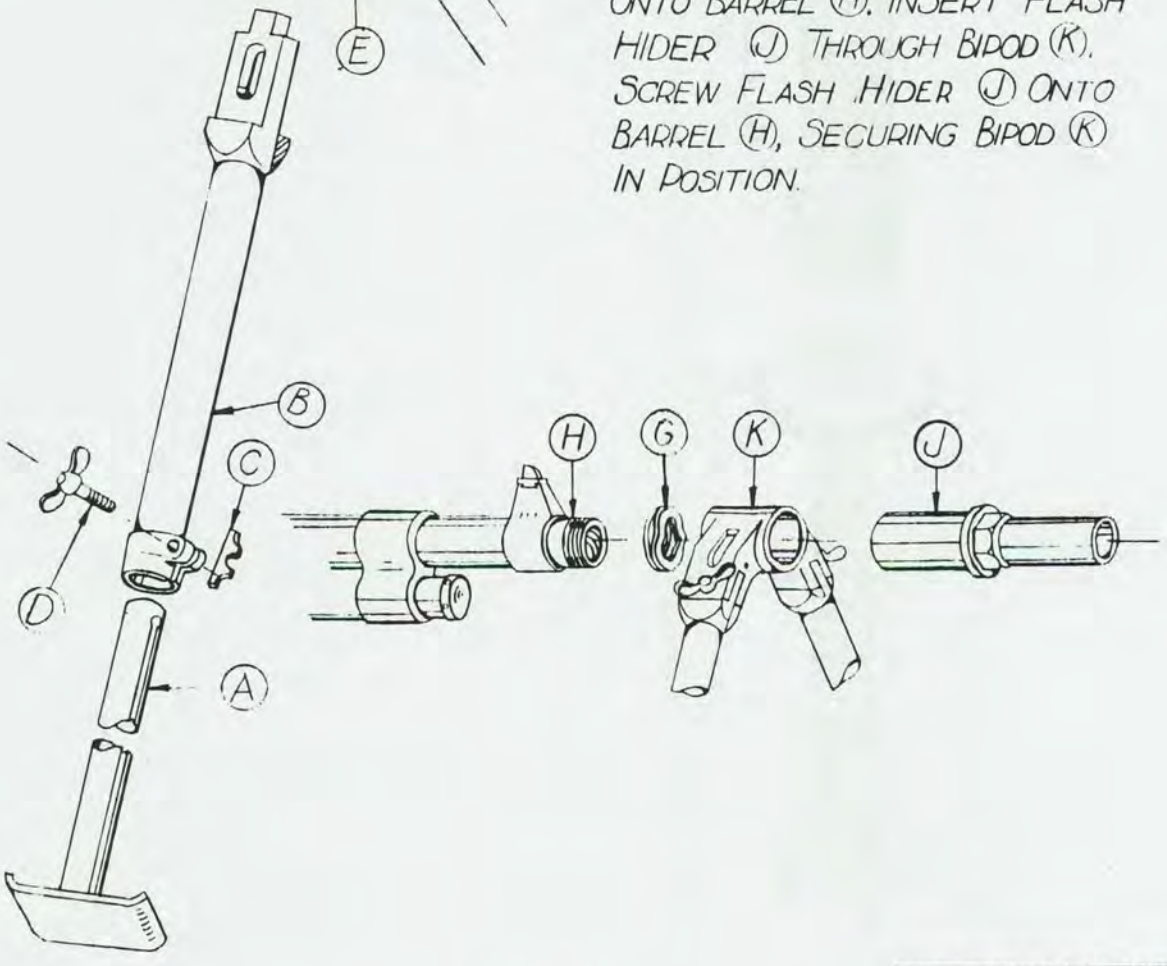
(48) SLIDE LEG (A) INTO TUBE (B). ALIGN THE KEYWAYS IN LEG (A) AND TUBE (B). INSERT KEY (C) INTO THE KEYWAY AND APPLY SCREW (D), SECURING LEG (A) IN PLACE.

(49) PLACE TUBE (B) IN POSITION IN BODY (E) AND SECURE WITH SCREW (F).

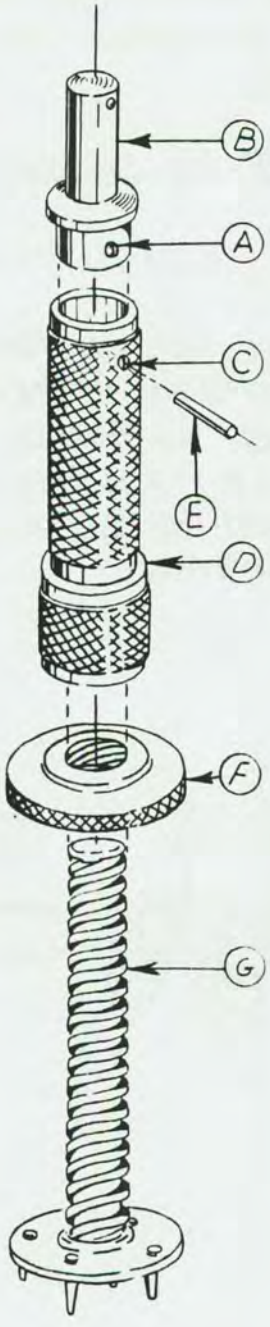


ASSEMBLY OF BIPOD TO RIFLE

(50) SLIDE FRICTION WASHER (G) ONTO BARREL (H). INSERT FLASH HIDER (J) THROUGH BIPOD (K). SCREW FLASH HIDER (J) ONTO BARREL (H), SECURING BIPOD (K) IN POSITION.



ASSEMBLY OF STOCK REST



(51) ALIGN HOLE (A) IN STEM (B) AND HOLE (C) IN NUT (D) AND TAP PIN (E) INTO PLACE. SCREW LOCK (F) ONTO LEG (G), AND SCREW NUT (D) ONTO LEG (G).

SMALL ARMS RIFLE, AUTO. CAL. .30 BROWNING M1918A2	ASSEMBLING	SHEET 19 OF 20

ASSEMBLY OF MAGAZINE

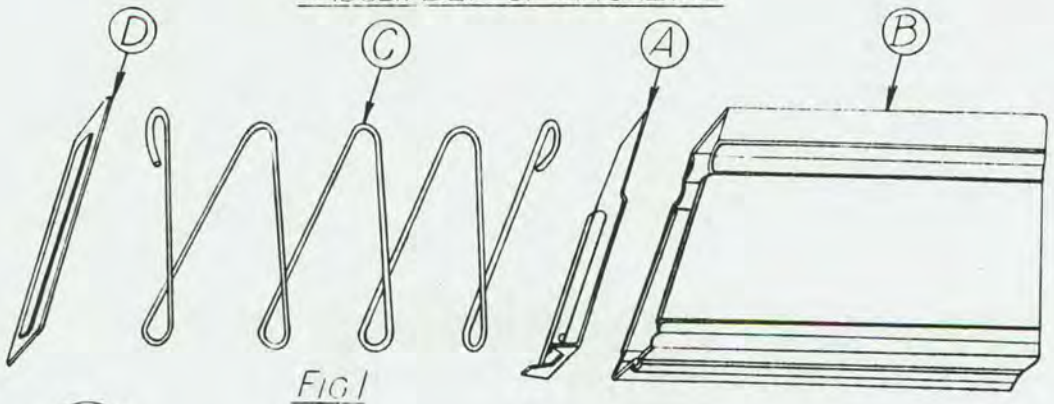
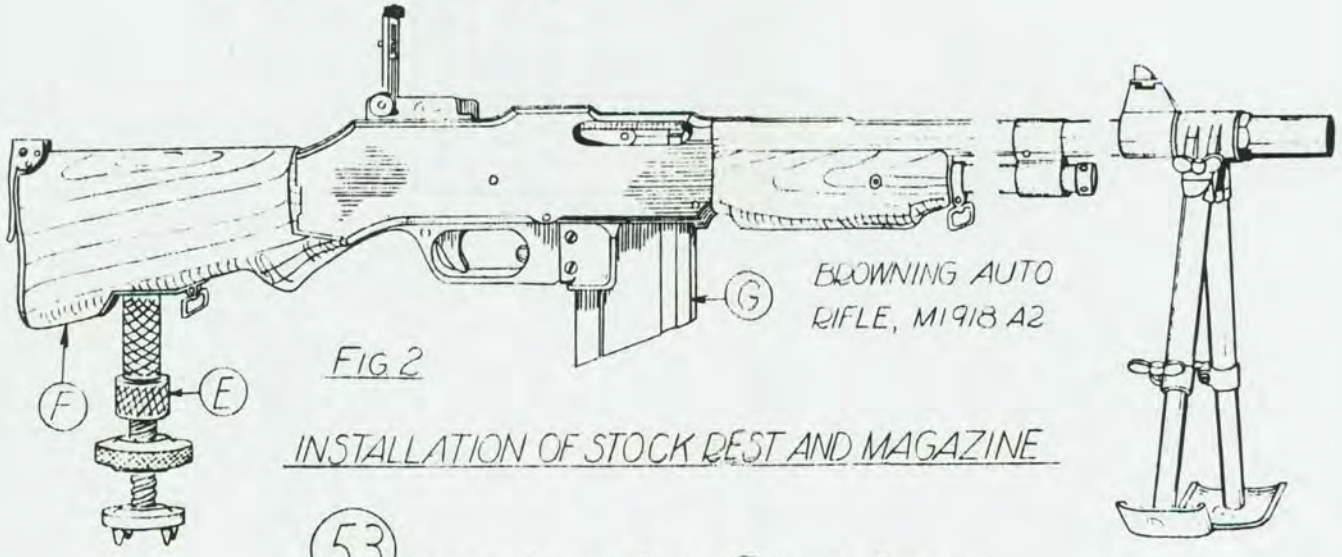


FIG 1

(52) INSERT THE FOLLOWER (A) INTO TUBE (B). COMPRESS SPRING (C) AGAINST FOLLOWER AND SLIDE BASE (D) INTO BOTTOM OF TUBE (B).



BROWNING AUTO RIFLE, M1918 A2

FIG 2

INSTALLATION OF STOCK REST AND MAGAZINE

(53) INSERT STOCK REST (E) INTO BUSHING IN STOCK (F).

(54) SLIDE MAGAZINE (G) INTO BOTTOM OF RECEIVER, AS SHOWN.

SMALL ARMS RIFLE, AUTO. CAL 30 BROWNING M1918 A2	ASSEMBLING	SHEET 20 OF 20

TOOLS REQUIRED

TOOL DWG. NO.	SHEET	OPER.	DET.
909180	1	1	B
909179	1	1	D
41-T 3369-40	2	5	
A2401	3	6	C
C7719A	5	11	B
C7719G	5	12	G
C7719M	5		FIG.1
908977	7	14	A
C64145	8	19	H
A77201	11	28	B
A77204	14	38	H
C64145	14	38	K
908981	15	41	K
908979	16	46	J
41-G-254-295	2	4	

REPLACES SHEET 20, B.S.D. UNIT NO. 2, ISSUE OF 3-5-43

ORDNANCE FIELD SERVICE

BASE SHOP DATA

Rifle, Automatic, Cal. .30 Browning, M1918A2

PREPARED UNDER THE DIRECTION OF THE CHIEF OF ORDNANCE

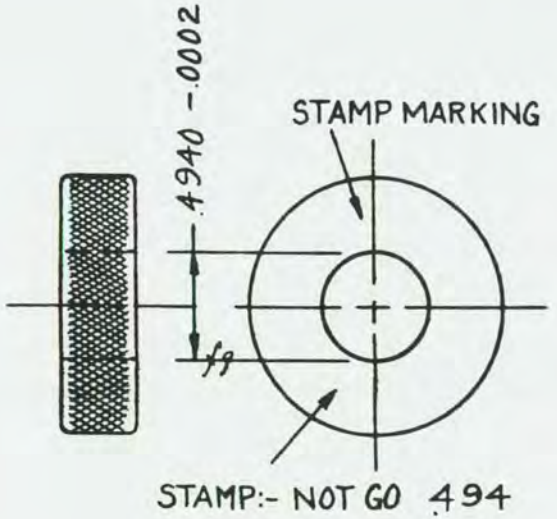
ROCK ISLAND ARSENAL - NOV., 1943

B.S.D. No.

Tool Drawings 3

A 77201

MARKING:-
.30 BAR M'18, M'18 A2 & .30 B.M. R.M. 22
C-9073 GAS PISTON
REJECTION RING FOR GAS PISTON
(FIELD SERVICE)
A 77201 ORD. DEPT. U. S. A.



PLAIN RING GAGE

AMERICAN GAGE DESIGN STANDARD

HARDEN TO ROCKWELL SCALE C63 MIN

LAP fg SURFACES
REMOVE ALL SHARP EDGES 33A

SUPERSEDES OLD TRACING SA-5800 UNDER REVISION DATE OF SEPT. 14, 1938.

REVISIONS		
COMPONENT		GAGE
DRG. NO.	DATE	DATE
C-9073	4-15-38	9-14-38

DRG. PERTAINS TO
B 113062 GAGE LISTS

SYMBOL

D'F'TSMAN	TRACER	L'D'G D'F'TSMAN
F.C.L.	F.C.L.	
CHECKER	CHECKER	CHIEF D'F'TSMAN
R.A.B.		

SUBMITTED:-
C S Reed
CAPT. ORD DEPT U. S. A.

APPROVED:-
LT. COL, ORD DEPT. U. S. A.

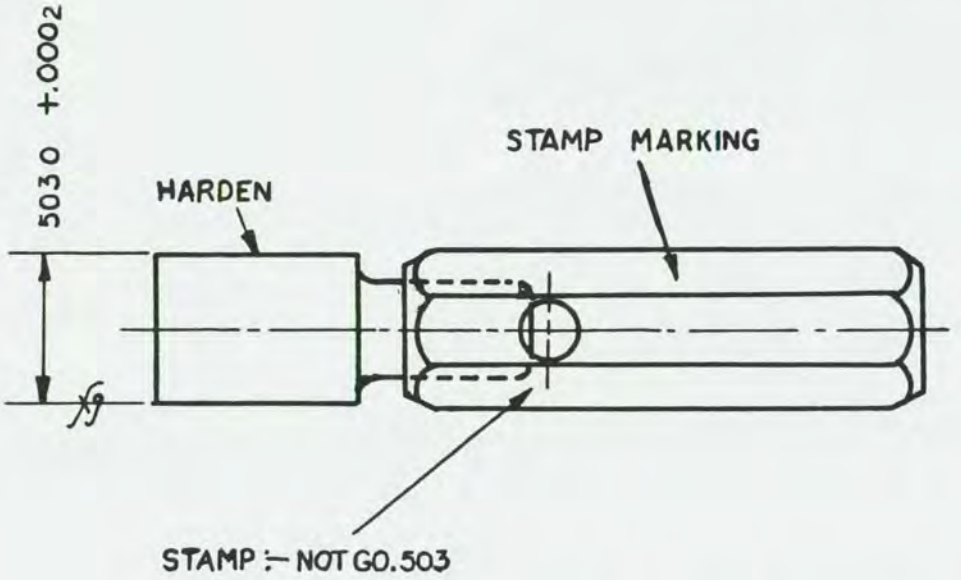
SPRINGFIELD ARMORY

DATE SEPT. 14, 1938

A 77201

A77204

MARKING:—
BRG. AUTO. RIFLE CAL. 30 M1918A2
C-64296 GAS CYLINDER REJECTION PLUG
FOR DIA. OF PISTON HOLE (FIELD SERVICE)
A77204 , ORD. DEPT. U.S.A. INSP.



S.E. PLAIN PLUG GAGE
AMERICAN GAGE DESIGN STANDARD
USE GO STD. BLANK

ROCKWELL HARDNESS C63 TO 66
NOT TO SCALE
LAP ⌭ SURFACES
REMOVE ALL SHARP EDGES 33A

REVISIONS

COMPONENT		GAGE
DRG. NO.	DATE	DATE
C64296	12-26-40	5-28-41

DRG. PERTAINS TO
B113062-1 GAGE LISTS

D'FTSMAN	TRACER	L'O&D'FTSMAN
P.a.R.	P.a.R.	[illegible]
CHECKER	CHECKER	CHIEF D'FTSMAN
RAB		[illegible]

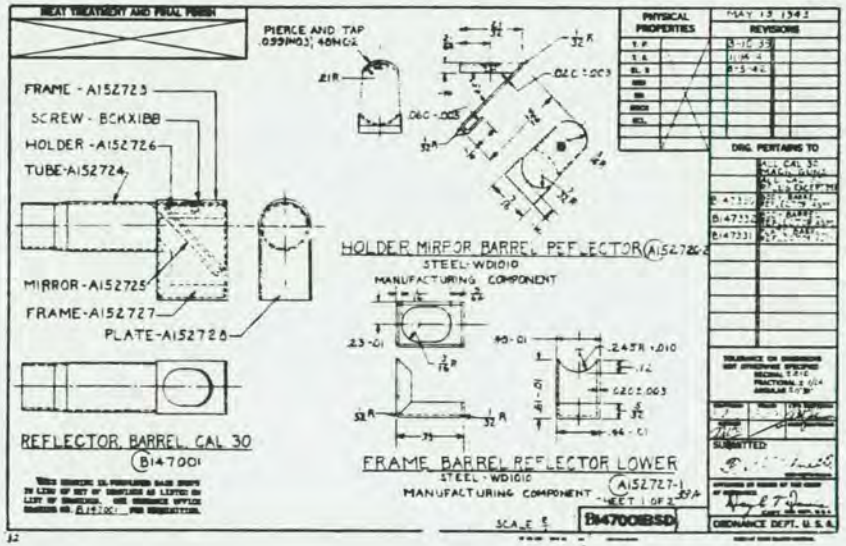
SUBMITTED:—
R. G. Pillsbury
CAPT. ORD. DEPT. U.S.A.

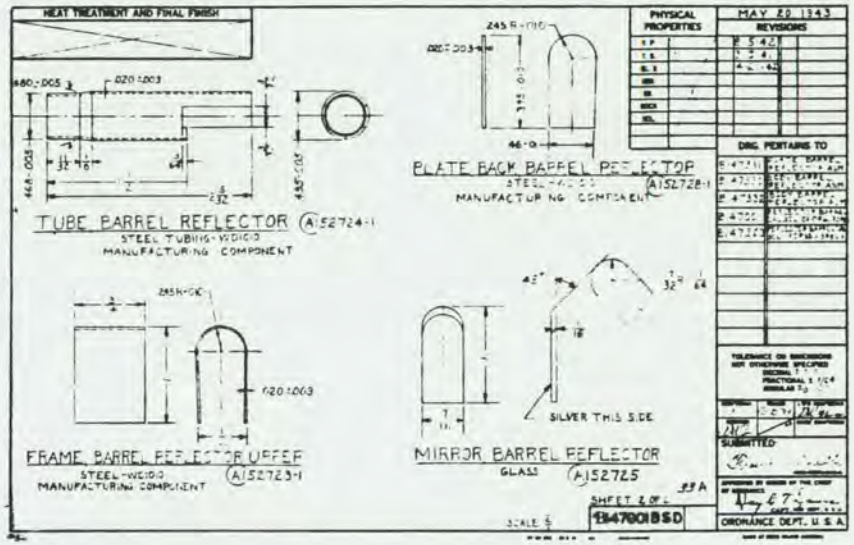
APPROVED:— BY ORDER OF THE CHIEF OF ORDNANCE
W. T. Moore
MAJ., ORD. DEPT. U.S.A.

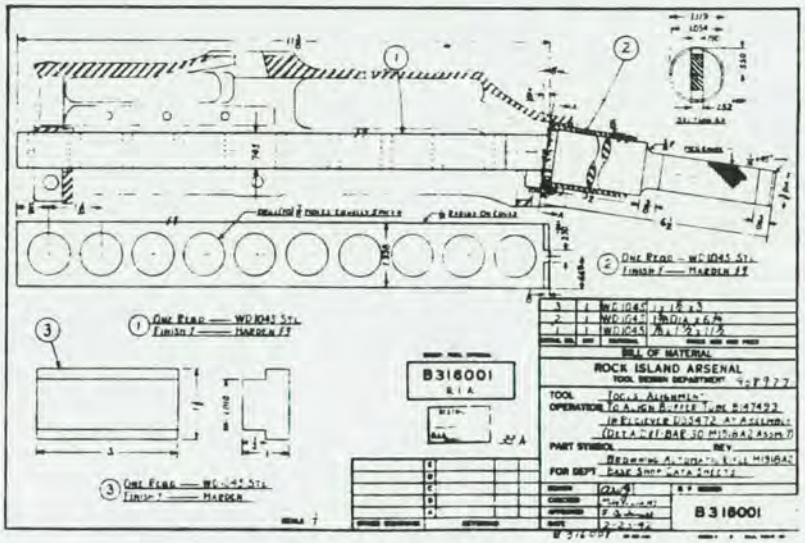
SPRINGFIELD ARMORY

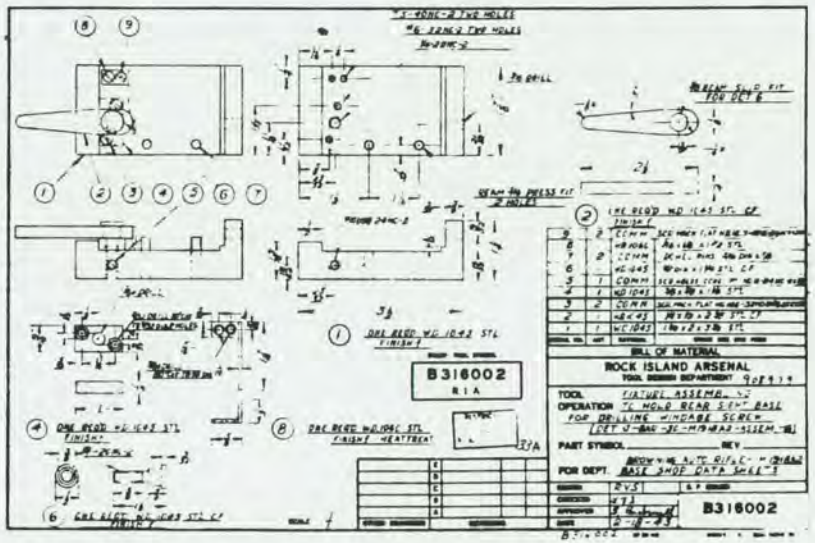
DATE MAY 28, 1941

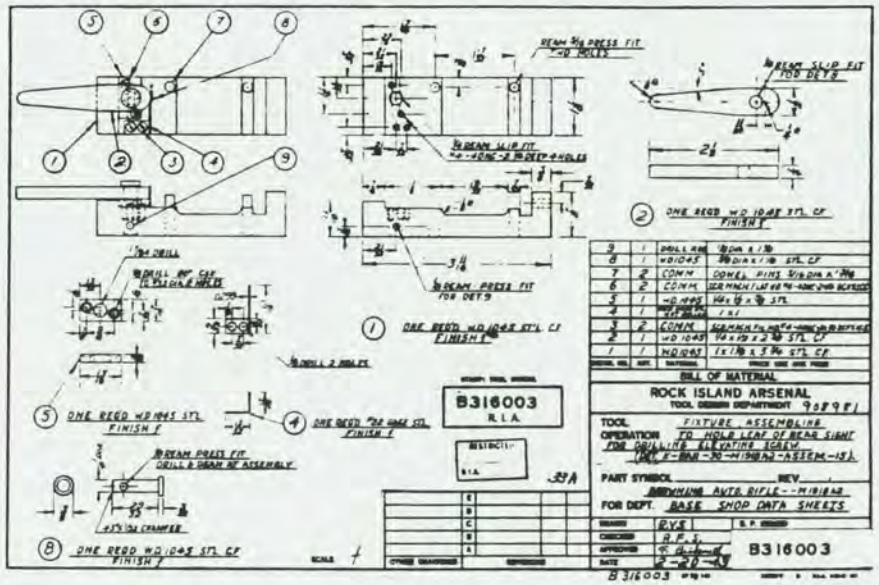
A77204


HEAT TREATMENT AND FINAL FINISH
PIERCE AND TAP .093 NO3, 48 NO2
FRAME - A152723
SCREW - BCHX188
HOLDER - A152726
TUBE - A152724
MIRROR - A152725
FRAME - A152727
PLATE - A152728
REFLECTOR, BARREL, CAL 30
B147001
HOLDER, MIRROR BARREL REFLECTOR A152728-2
STEEL - WD1010
MANUFACTURING COMPONENT
FRAME, BARREL REFLECTOR LOWER
STEEL - WD1010
MANUFACTURING COMPONENT
A152727-1
SHEET 1 OF 3
SCALE 1
B147001BSD
PHYSICAL PROPERTIES
MAY 13 1943
REVISIONS
DRG. PERTAINS TO
SUBMITTED
ORDNANCE DEPT. U.S.A.


HEAT TREATMENT AND FINAL FINISH
TUBE BARREL REFLECTOR A152724-1
STEEL TUBING - WD1010
MANUFACTURING COMPONENT
PLATE BACK BARREL REFLECTOR A152728-1
STEEL - WD1010
MANUFACTURING COMPONENT
FRAME, BARREL REFLECTOR UPPER A152723-1
STEEL - WD1010
MANUFACTURING COMPONENT
MIRROR BARREL REFLECTOR
GLASS A152725
SILVER THIS SIDE
SHEET 2 OF 3
SCALE 1
B147001BSD
PHYSICAL PROPERTIES
MAY 20 1943
REVISIONS
DRG. PERTAINS TO
SUBMITTED
ORDNANCE DEPT. U.S.A.


1 ONE REQD — WD1045 STL FINISH 7 — HARDEN ff
2 ONE REQD — WC1045 STL FINISH 7 — HARDEN ff
3 ONE REQD — WC1045 STL FINISH 7 — HARDEN
B316001
R I A
BILL OF MATERIAL
ROCK ISLAND ARSENAL
TOOL DESIGN DEPARTMENT
TOOL Tool, Alignment
OPERATION To align B-Rifle Tube B147492 in Receiver D33472 at Assembly (Delta Ref-Bar 30 Mirror) Assem 7
PART SYMBOL
REV.
FOR DEPT. Reaming Automatic Rifle Mirror
Base Shop Data Sheet 2
B316001


1 ONE REQD WD 1045 STL
2 ONE REQD WC1045 STL CF FINISH 7
4 ONE REQD WC1045 STL
6 ONE REQD WC1045 STL CF
8 ONE REQD WC1045 STL FRONT HEATTREAT
B316002
R I A
BILL OF MATERIAL
ROCK ISLAND ARSENAL
TOOL DESIGN DEPARTMENT
TOOL Fixture, Assembly
OPERATION To Hold Rear Sight Base for Drilling Windage Screw (Set up-Bar 30-Mirror Assem 8)
PART SYMBOL
REV.
FOR DEPT. Base Shop Data Sheet 3
B316002

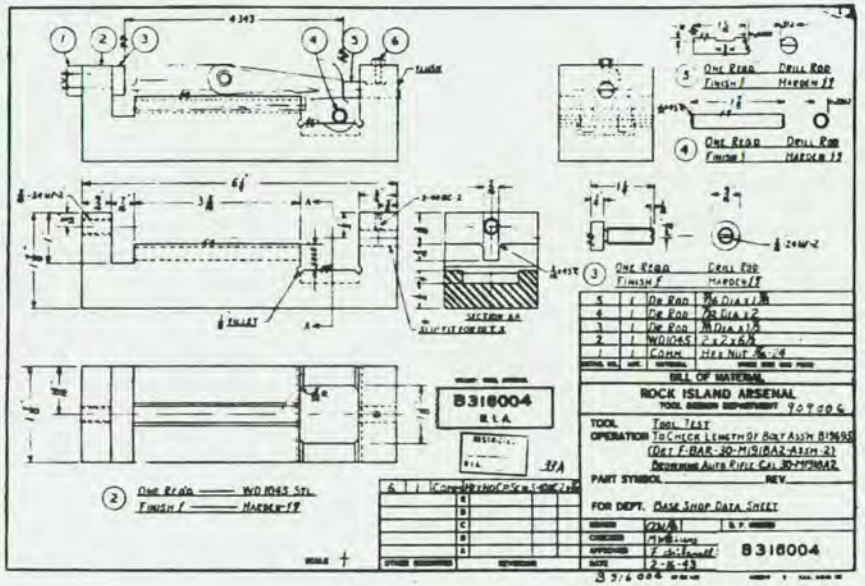


9	1	DRILL ROD	10 DIA x 10
8	1	WD1045	3/8 DIA x 1/8 STL CF
7	2	COMM	DOWEL PINS 5/16 DIA x 3/4
6	2	COMM	SEMS #10-32 x 3/4 SLOTTED
5	1	WD 1045	1/4 x 1/2 x 3/8 STL
4	1		1 x 1
3	2	COMM	SEMS #10-32 x 3/4 SLOTTED
2	1	WD 1045	1/4 x 1/2 x 2 3/8 STL CF
1	1	WD1045	1 x 1 3/8 x 3 3/4 STL CF

BILL OF MATERIAL
ROCK ISLAND ARSENAL
TOOL DESIGN DEPARTMENT 9089 E1

TOOL FIXTURE, ASSEMBLING
OPERATION TO HOLD LEAF OF REAR SIGHT FOR DRILLING ELEVATING SCREW
DET F-BAR-30-M1918A2-ASSEM-15
PART SYMBOL REV
BROWNING AUTO RIFLE - M1918A2
FOR DEPT. BASE SHOP DATA SHEETS

B316003
R.I.A.
.39 A
B316003

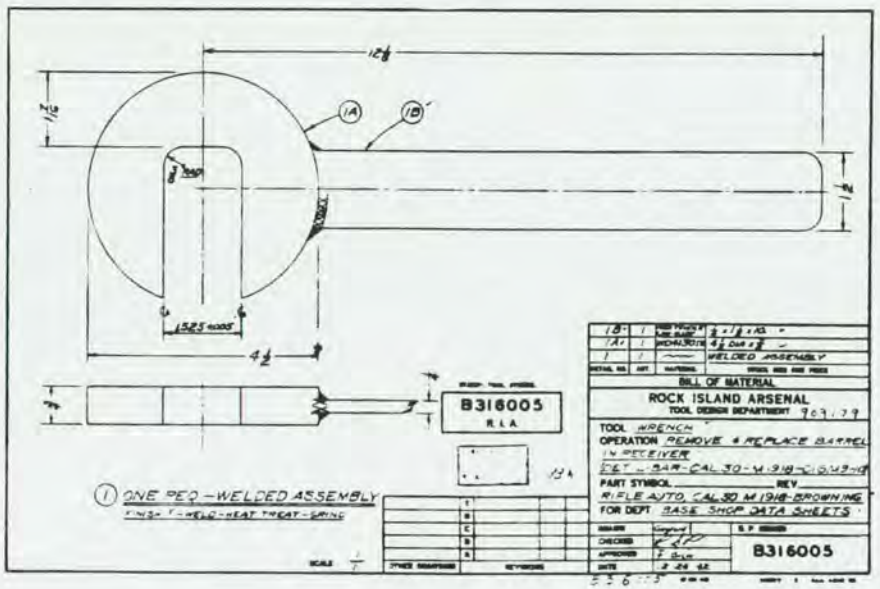


5	1	DR ROD	3/16 DIA x 1 3/8
4	1	DR ROD	3/8 DIA x 2
3	1	DR ROD	1/4 DIA x 1 3/8
2	1	WD1045	2 x 2 x 6 1/8
1	1	COMM	HEX NUT 3/8-24

BILL OF MATERIAL
ROCK ISLAND ARSENAL
TOOL DESIGN DEPARTMENT 9076 D6

TOOL TOOL TEST
OPERATION TO CHECK LENGTH OF BOLT ASSY B316905 (DET F-BAR-30-M1918A2-ASSM-2)
DESIGNING AUTO RIFLE CAL 30 M1918A2
PART SYMBOL REV
FOR DEPT. BASE SHOP DATA SHEETS

B316004
R.I.A.
.39 A
B316004

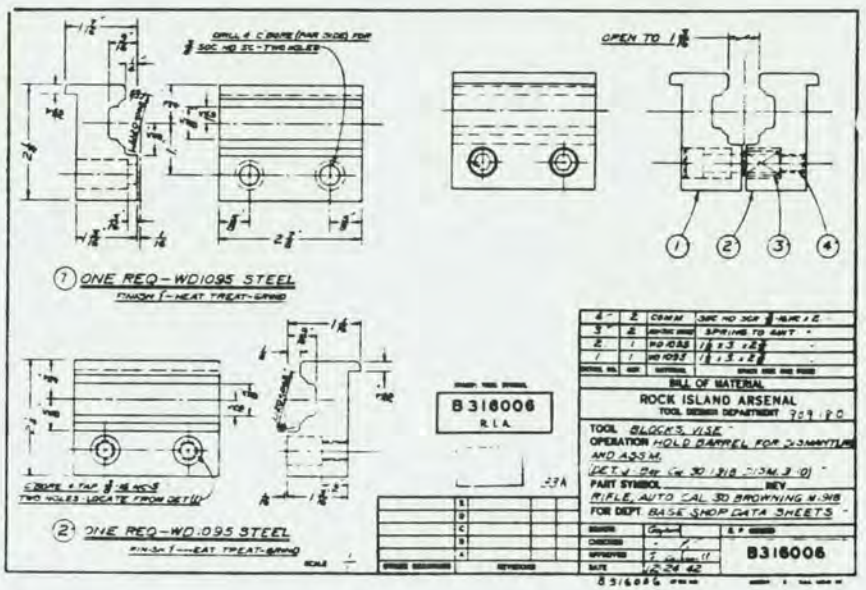


1B	1	WELDMENT	2 x 1 1/2 x 10
1A	1	WD4130	4 1/2 DIA x 1/2
1	1		WELDED ASSEMBLY

BILL OF MATERIAL
ROCK ISLAND ARSENAL
TOOL DESIGN DEPARTMENT 9631 79

TOOL WRENCH
OPERATION REMOVE & REPLACE BARREL IN RECEIVER
DET - BAR-CAL 30-M 1918-(1943-15)
PART SYMBOL REV
RIFLE AUTO CAL 30 M 1918 BROWNING
FOR DEPT. BASE SHOP DATA SHEETS

B316005
R.I.A.
.13 A
B316005



4	2	COMM	SEMS NO 3CR 3/8-16UNC x 2
3	2		SPRING TO SUIT
2	1	WD 1095	1 1/2 x 3 x 2 3/8
1	1	WD 1095	1 1/2 x 3 x 2 3/8

BILL OF MATERIAL
ROCK ISLAND ARSENAL
TOOL DESIGN DEPARTMENT 969 80

TOOL BLOCKS, VISE
OPERATION HOLD BARREL FOR ASSEMBLING AND ASSEM.
DET V-Bar (Ge 30 1918 -13M 3 0)
PART SYMBOL REV
RIFLE, AUTO CAL 30 BROWNING M 1918
FOR DEPT. BASE SHOP DATA SHEETS

B316006
R.I.A.
.23 A
B316006

LINE NUMBER	LIST OF DRAWINGS	DRAWING NUMBER	BREECHING SPACE "B"	HEAT TREATMENT & FINAL FINISH: HEAT TO 1820-1440°F. QUENCH IN WATER TEMPER AT 350°F. ROCKWELL C64-65	HEADSPACE LENGTH "L"
1	GAGE, HEADSPACE, CAL. 30				
2		C7719A	2.654		1.94
3		C7719B	2.655		1.941
4		C7719C	2.656		1.942
5		C7719D	2.657		1.943
6		C7719E	2.658		1.944
7		C7719F	2.659		1.945
8		C7719G	2.660		1.946
9		C7719H	2.661		1.947
10		C7719K	2.662		1.948
11		C7719L	2.663		1.949
12		C7719M	2.664		1.950
13		C7719N	2.665		1.951
14		C7719P	2.666		1.952
15		C7719Q	2.667		1.953
16		C7719R	2.668		1.954
17		C7719S	2.669		1.955
18					

LINE NUMBER	LIST OF SPECIFICATIONS	SPECIFICATION NUMBER	REVISION
1	GAGE, HEADSPACE, CAL. 30		
2	TOOL STEEL CARBON AND ALLOY	57-108	
3			
4			
5			
6			

NOTE:
GAGES 1942 AND 1944 ARE FOR USE IN THE MANUFACTURE OF THE U.S. RIFLE CAL. 30 M1
GAGES 1.94 AND L944 ARE FOR USE IN THE MANUFACTURE OF OTHER RIFLES.
GAGE L946 IS FOR USE AS MAX. GAGE IN FINAL INSPECTION OF OVERHAUL RIFLES.
GAGE 1.95 IS FOR INSPECTION IN THE FIELD AS A HEADSPACE LIMIT FOR SERVICEABLE RIFLES
THE FULL SET OF GAGES TO BE USED IN AMMUNITION AND RIFLE TESTING WHEN HEADSPACING BETWEEN THE PRESCRIBED LIMITS IS DESIRABLE.

DRAW RIM TO ROCKWELL SCALE C 50 TO 55

SCALE 2/1

NAME OF MANUFACTURER
ORD. DEPT. U.S.A.
HEADSPACE GAGE
CAL..30

HEADSPACE DIMENSION, PIECEMARK & REVISION SYMBOL TO BE STAMPED HERE.

DETAIL OF MARKING

.4425
EXACT

MASTER RING SET UP FOR PRODUCING "L"

L=.0002 TO DIA. 442.5 AT INTERSECTION FOR COMPUTING ONLY

STAMP MARKING HERE

.0935 (NO. 42) CENTER DRILL BOTH ENDS

B REFERENCE

GAGE, HEADSPACE, CAL. .30
CARBON TOOL STEEL C95
FINISH

C7719-9

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRACING C7719 UNDER REVISION DATE OF MAY 8, 1936

0 2 INCHES

C 7719

MARCH 5, 1924

REVISIONS

4	5-8-36	12	5-11-38
5	8-1-36	13	6-2-39
6	6-1-37	14	9-3-40
7	7-2-37	15	2-13-41
	7-27-37	16	10-10-41
9	9-24-37	17	6-2-42
	11-2-37	18	12-19-42
11	1-10-38	19	1-7-43

DRG. PERTAINS TO
STANDARD FOR CAL. 30 RIFLES & MACHINE GUNS
B113062
GAGE LISTS

REVISIONS

20	5-28-43

SYMBOL
FCG-18

SUBMITTED

CHIEF OF ORDNANCE

APPROVED

ORDNANCE DEPT U.S.A.

LINE NUMBER	LIST OF DRAWINGS	DRAWING NUMBER	REVISION
1	TOOL, COMBINATION	C 64145	
2			
3			
4			

LINE NUMBER	LIST OF SPECIFICATIONS	SPECIFICATION NUMBER	REVISION
1			
2	MANUFACTURE AND INSPECTION OF SMALL ARMS		
3	WEAPONS AND ACCESSORIES	U.S.A. 52-0-1	
4	METALS; GENERAL SPECIFICATION FOR INSPECTION OF	FED. QQ-M-151	
5	STANDARD SPECIFICATIONS FOR MARKING SHIPMENTS	U.S.A. 100-2	
6	FINISHES, PROTECTIVE, ON IRON AND STEEL PARTS (FOR		
7	ORDNANCE MATERIEL)	U.S.A. 57-0-2	
8	STEEL, CARBON AND ALLOY, BARS	U.S.A. 57-107	
9			

HEAT TREATMENT & FINAL FINISH

HEAT TO 1450°-1475° F. QUENCH IN WATER TEMPER 500°-550° F. ADJUST TO OBTAIN SPECIFIED HARDNESS - FINISH-TYPE II (PHOSPHATE COATING)

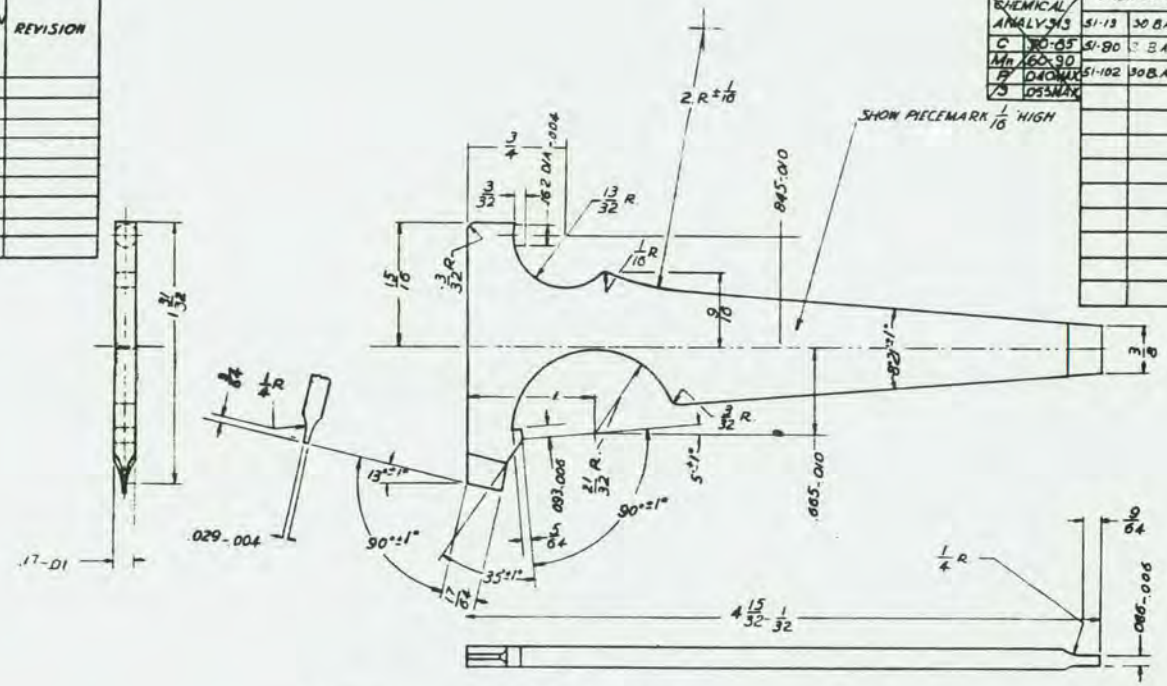
PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL 2	
RED	
BR.	
ROCK	C 46-50
SCL	

CHEMICAL ANALYSIS		DRG. PERTAINS TO
C	.30-.65	51-13 .30 B.A.R. - M 1 8
Mn	.60-.90	51-90 .30 B.A.R. - M1A1
P	.040 MAX	51-102 .30 B.A.R. - M1A2
S	.055 MAX	

MARCH 1, 1937

REVISIONS

1	6-15-38	
2	9-5-42	
3	10-24-42	



TOOL, COMBINATION Ⓒ 64145

STEEL-W.D. 1075 FINISH 5

LIST OF DRAWINGS & SPECIFICATIONS SHOWING REVISIONS IN EFFECT ON

SYMBOL

DET 1

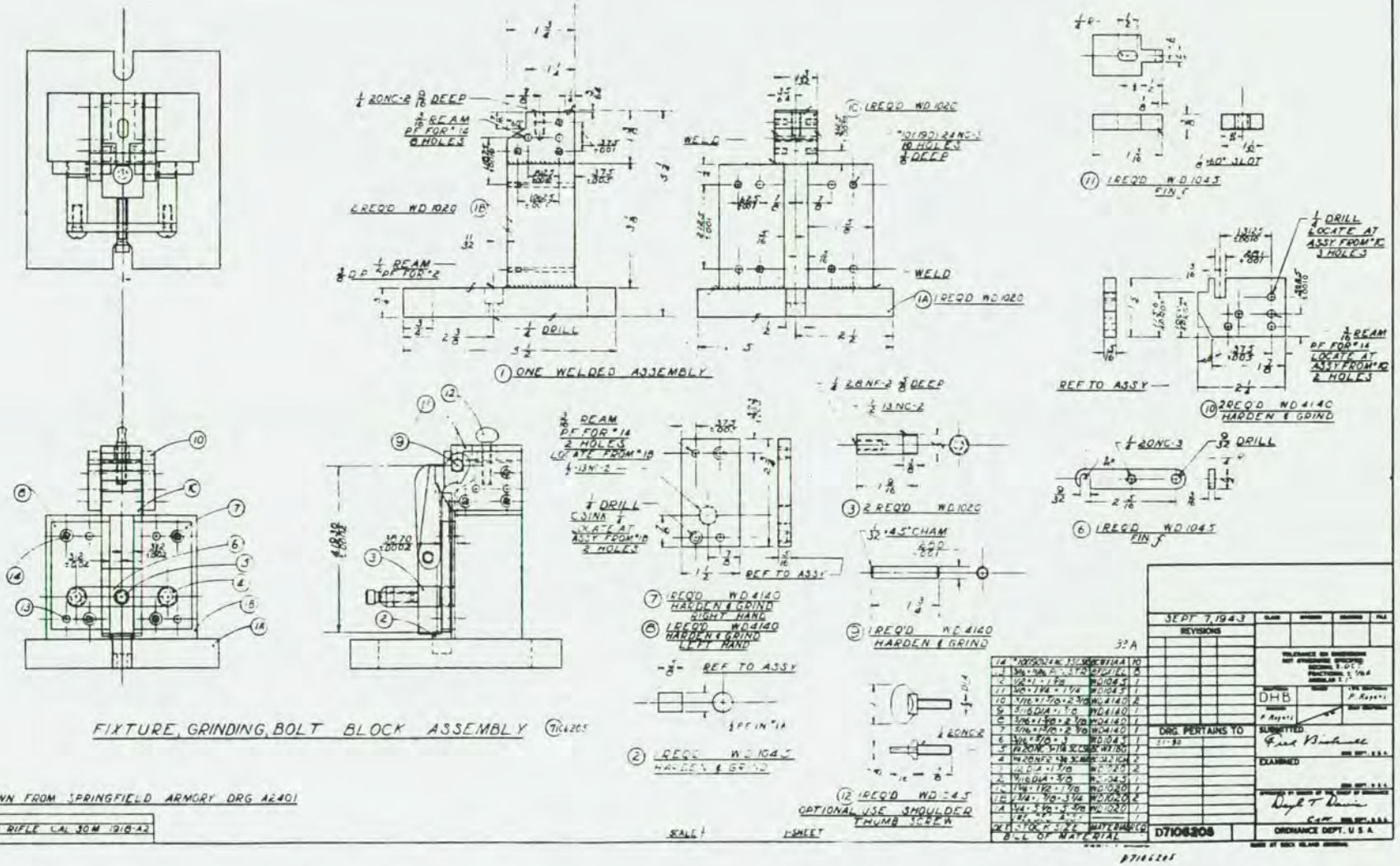
TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.

SUPERSEDES OLD TRACINGS A7364 & B6935 UNDER REVISION DATE OF MARCH-1, 1937

SCALE 2/1

C 64145

ORDNANCE DEPT. U.S.A.


1 ONE WELDED ASSEMBLY
2 REQ'D WD 1045
OPTIONAL USE SHOULDER THUMB SCREW
FIXTURE, GRINDING, BOLT BLOCK ASSEMBLY
NOTE REDRAWN FROM SPRINGFIELD ARMORY DRG A2401
BROWNING AUTO RIFLE CAL 30M 1918-A2
SCALE 1
1 SHEET
SEPT 7, 1943
REVISIONS
DRG. PERTAINS TO
D7106205
ORDNANCE DEPT. U.S.A.